SETUP & OPERATION MANUAL

8" DELUXE JOINTER

FEATURES

- Large surface, ground cast-iron tables for stability and added support when feeding longer stock.
- Heavy-duty, three-knife cutter head for clean, fast, superior finish cuts.
- Jackscrew system for quick, easy knife adjustment.
- Large, heavy-duty, center-mounted cast-iron fence with 45°, 90° and 135° positive stops.
- Independent in-feed and out-feed table adjustment hand wheels. Built-in rabbeting ledge.
- 4" dust collection port.
- Includes: 2 hand-paddle style push blocks with onboard storage mounts.
- Magnetic safety switch with overload protection.
- Convenient front to back fence adjustment hand wheel.
- Motor mounted on vibro-eliminators for smooth, quiet operation.

SPECIFICATIONS

TABLE SIZE
9 1/4" x 74 7/8" (235 x 1900 mm)

IN-FEED TABLE (L X W)
36 1/2" x 9 1/4" (936 x 235 mm)

OUT-FEED TABLE (L X W)
36 1/2" x 9 1/4" (936 x 235 mm)

MAXIMUM CUTTING WIDTH
8" (203 mm)

MINIMUM CUTTING DEPTH
1/2" (13 mm)

RABBETING CAPACITY
1/2" (13 mm)

FENCE SIZE
4" x 38" (102 x 965 mm)

CUTTER HEAD SPEED
5500 RPM

NUMBER OF KNIVES
3 / HELICAL

BASE DIMENSIONS (L X W)
29" x 17" (736.6 x 431.8 mm)

MOTOR
M1 - 2 HP, 220 V, 1 Ph, 12 A
M2 - 2 HP, 220 V, 3 Ph, 6 A
M3 - 2 HP, 600 V, 3 Ph, 3 A

WEIGHT
572 LBS (260 kg)

MODEL
#80-200L
#80-200LHC

GENERAL
GENERAL INTERNATIONAL

REVISION 1 - JANUARY 28/10
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THANK YOU for choosing this General® International model 80-200L or 80-200LHC 8" Deluxe Jointer. This jointer has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this jointer as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of jointer and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International ® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

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RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate this jointer when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the jointer is in operation; do not permit them to operate the jointer.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. **Stay alert!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector. Wear face, eye, ear, respiratory and body protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the jointer is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating.
9. Keep hands well away from knives and all moving parts. Use a push stick to feed stock, and a brush, not hands, to clear away chips and dust.
10. Be sure that the knives are securely installed in the cutterhead.
11. Always use clean, properly sharpened knives. Dirty or dull knives are unsafe and can lead to accidents.
12. If using a power feeder, stop the feeder before stopping the jointer.
13. Do not push or force stock into the cutter head. The jointer will perform better and more safely when working at the rate for which it was designed.
14. Be sure that the cutter head has gained full operating speed before starting to joint.
15. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.
16. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning be sure it is properly re-attached before using the tool again.
17. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equipment malfunction or risk of injury.
18. Never stand on machinery. Serious injury could result if the tool is tipped over or if the cutting tool is unintentionally contacted.
19. Always disconnect the tool from the power source before servicing or changing accessories such as knives, or before performing any maintenance or cleaning, or if the machine will be left unattended.
20. Make sure that the switch is in the "OFF" position before plugging in the power cord.
21. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
22. Do not use this jointer for other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use.

Additional Safety Instructions for Jointers

Because each shop situation is unique, no list of safety guidelines can ever be complete. The most important safety feature of any shop is the knowledge and good judgement of the user. Use common sense and always keep safety considerations, as they apply to your individual shop conditions, first and foremost in mind. If you have any doubts about the safety of an operation you are about to perform: STOP! Do not perform the operation until you have validated from qualified individuals if the operation is safe to perform and what is the safest method to perform it.

1. WORK PIECE KICKBACK
Kickback is when the work piece is ejected at high speeds from the jointer table by the force of the cutter head. To minimize the risk of injury from kickback, always use push blocks and wear safety glasses. Do not operate this machine if you do not understand kickback, its causes and how to avoid it.

2. CUTTER HEAD ALIGNMENT
To reduce the risk of injury and to avoid kick-back, keep the top edge of the outfeed table aligned with the top dead center edge of the knife.

3. PUSH BLOCKS
Always use push blocks when jointing. Never pass your bare hands directly over the cutter head without a push block to hold and guide the workpiece.

4. WORKPIECE SUPPORT
To make safe cuts and reduce the risk of injury, support the workpiece adequately at all times. Never attempt to make a cut with an unstable workpiece.

5. KICKBACK ZONE
The kickback zone on a jointer is the area directly in the path through and off of the end of the infeed table. Never stand or allow others to stand in this area during operation.

6. MAXIMUM DEPTH OF CUT
The maximum depth of cut for one pass is 1/8". Never attempt to remove more material than 1/8" in any single pass.

7. JOINTING WITH THE GRAIN
Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

8. KEEPING GUARDS IN PLACE
Except when rabbeting, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

9. PROPER CUTTING
Always move the work piece over the cutter head from the infeed table towards the outfeed table until the work piece has passed completely over the cutter head. Never back the work piece towards the infeed table.

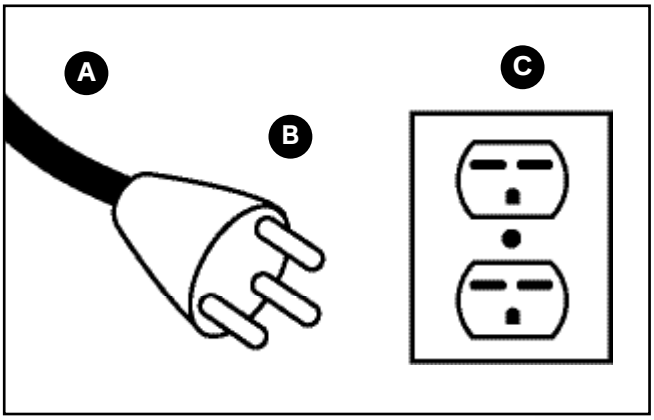
10. USING GOOD WORK PIECE STOCK
Jointing safety begins with the stock used with the machine. Inspect the work piece carefully before jointing it. Never joint a board that has loose knots, staples, nails or other embedded foreign objects. If you have the slightest doubt about the structural integrity or stability of a board: Do Not Joint It.

ELECTRICAL REQUIREMENTS

BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.

NOTE: VOLTAGE REQUIREMENTS AND AMPERAGE DRAW FOR M2 & M3 3-PHASE MOTORS MAY NOT BE FULLY DESCRIBED IN THIS MANUAL. FOR COMPLETE ELECTRICAL REQUIREMENTS REFER TO THE MOTOR I.D. NAME PLATE ON THE MACHINE. IF IN DOUBT CONSULT A LICENSED QUALIFIED ELECTRICIAN BEFORE PROCEEDING.



GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock to the operator. The motor of this machine is wired for 220V single phase operation and is equipped with a 3-conductor cord **A** and a 3-prong grounded plug **B** to fit a matching grounding type receptacle **C**.

DO NOT MODIFY THE PLUG PROVIDED ! If it will not fit your receptacle, have the proper receptacle installed by a qualified electrician.

CHECK with a qualified electrician or service person if you do not completely understand these grounding instructions, or if you are not sure the tool is properly grounded.

CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

The use of an extension cord is not generally recommended for 220V equipment. If you find it necessary, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

If you find it necessary to use an extension cord with your machine make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE - MINIMUM GAUGE FOR CORD

AMPERE RATING	TOTAL LENGTH OF CORD IN FEET				
	220 VOLTS	50 FEET	100 FEET	200 FEET	300 FEET
	AWG				
< 5	------->	18	16	16	14
6 TO 10	------->	18	16	14	12
10 TO 12	------->	16	16	14	12
12 TO 16	------->	14	12	* NR	* NR

*** NR = Not Recommended**

8” DELUXE JOINTER

80-200L & 80-200LHC

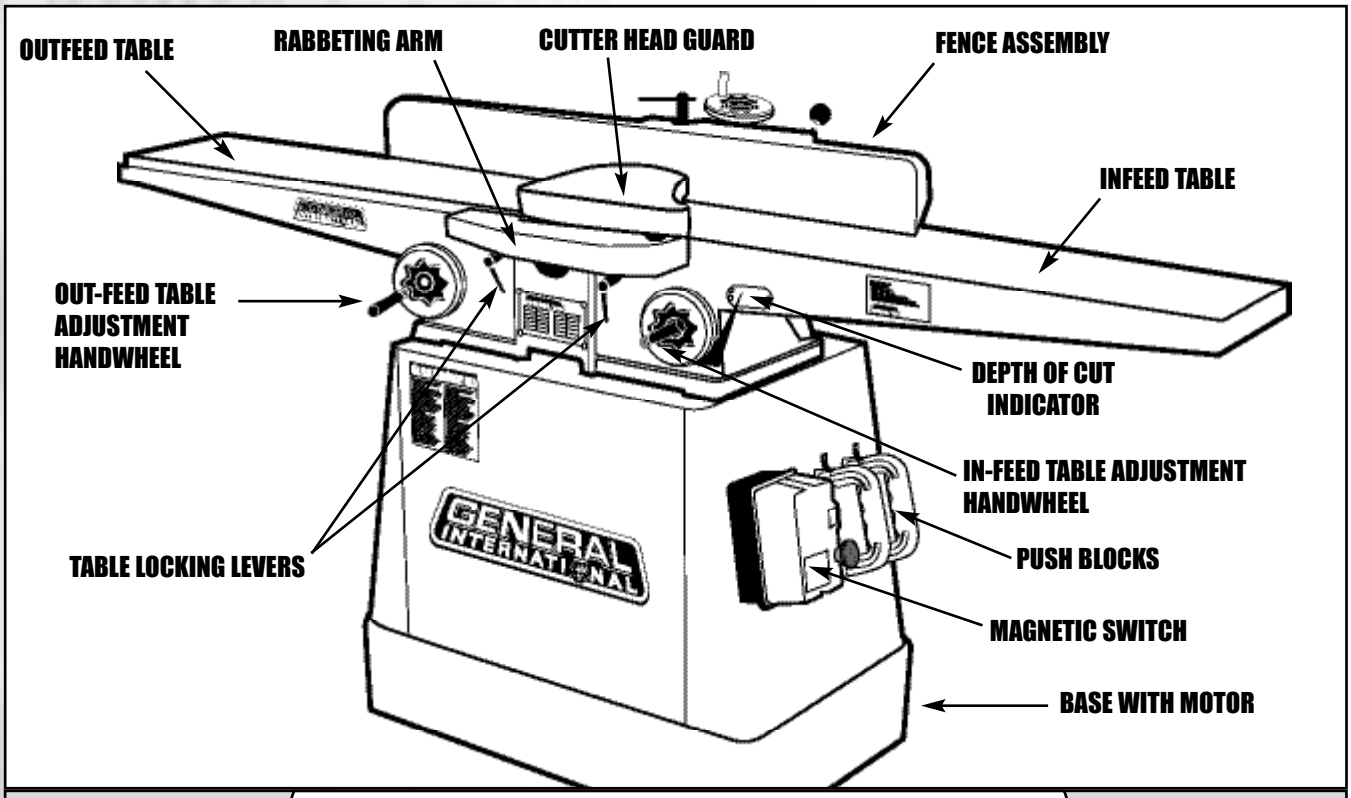
BASIC FUNCTIONS

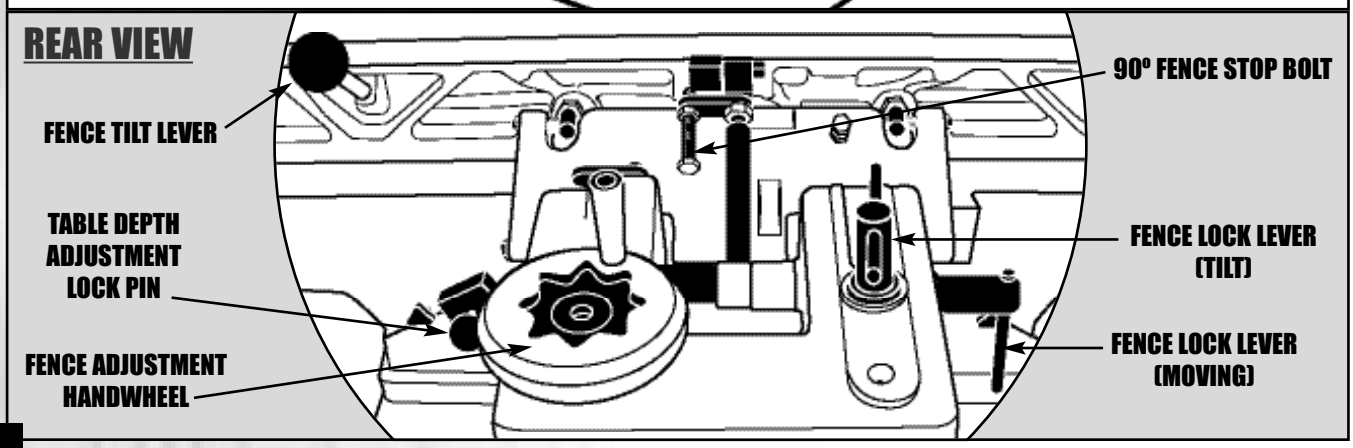
This 8” jointer is designed for face and edge jointing in solid wood only. The unit is not designed nor should it be used to surface or prepare, plywood, wood panelling, particleboard, MDF nor any other wood based by-products nor any non-wood based materials.

This 8” jointer is offered with 2 different cutter head options as follows:

- **Model 80-200L M1 –** 8” jointer with standard 3-knife cutter head;
- **Model 80-200LHC M1 -** 8” jointer with “Byrd” style helical cutter head with reversible four-sided carbide inserts.

IDENTIFICATION OF MAIN PARTS AND COMPONENTS





UNPACKING - MODELS 80-200L & 80-200LHC

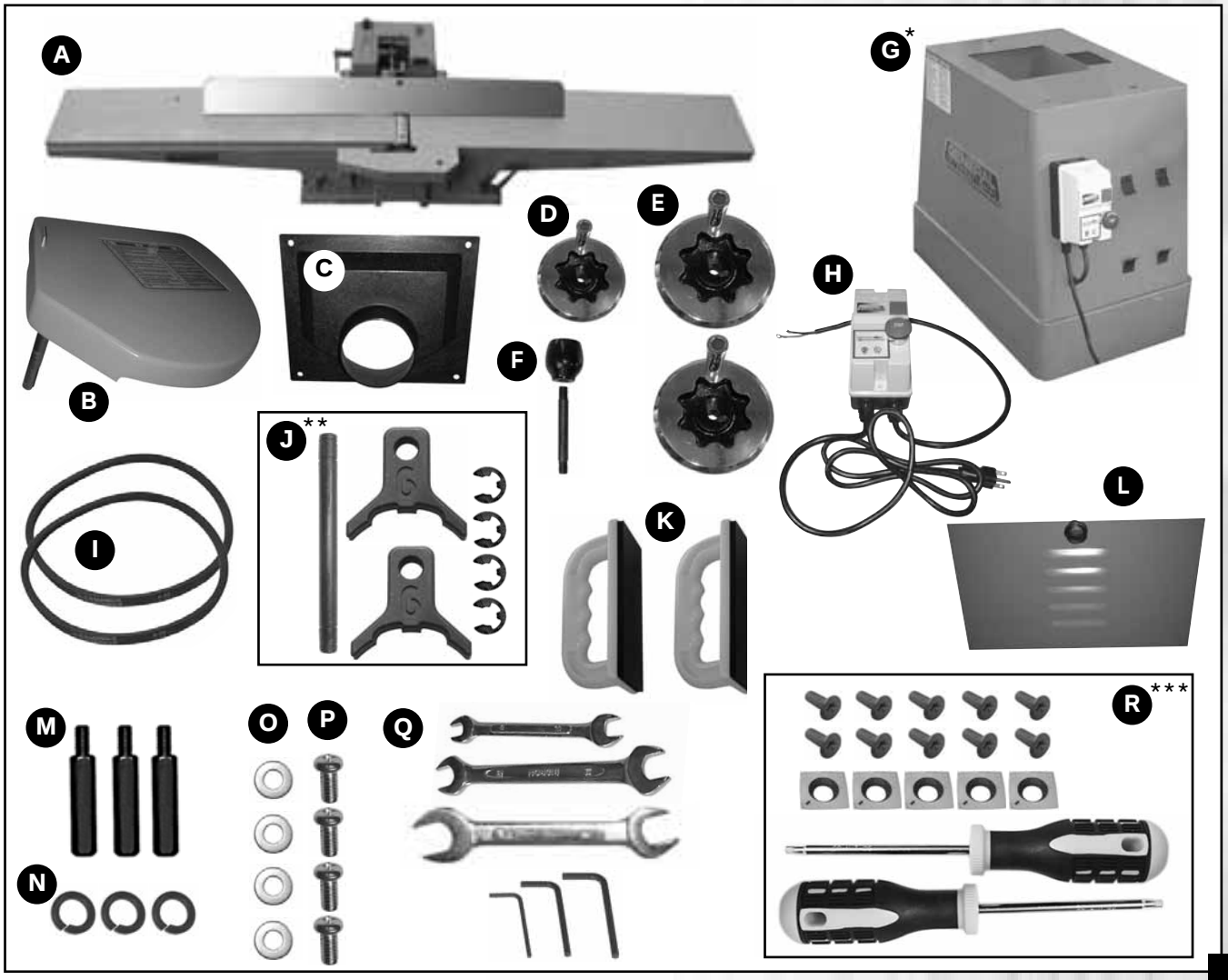
Carefully unpack and remove the unit and its components from its shipping crate and check for missing or damaged items as per the list of contents below.

NOTE: Please report any damaged or missing items to your GENERAL® INTERNATIONAL distributor immediately.

LIST OF CONTENTS **QTY**

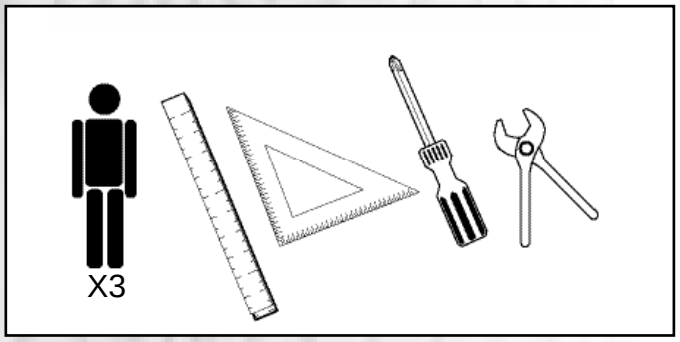
- **A** - JOINTER ASSEMBLY W/FENCE....1
- **B** - CUTTER HEAD GUARD....1
- **C** - DUST PORT....1
- **D** - 4" HAND WHEEL....1
- **E** - 6" HAND WHEEL....2
- **F** - FENCE TILT LEVER....1
- **G*** - BASE....1
- **H** - MAGNETIC SAFETY SWITCH....1
- **I** - V-BELT....2
- **J**** - KNIFE SETTING GAUGE
  - Knife setting gauge rod....1
  - Knife setting gauge foot....2
  - E-clip....4
- **K** - PUSH BLOCK....2
- **L** - BASE DOOR....1
- **M** - MOUNTING BOLT....3
- **N** - LOCK WASHER....3
- **O** - FLAT WASHER....4
- **P** - PHILLIPS HEAD SCREW....4
- **Q** - TOOLS
  - 8-10 mm open end wrench....1
  - 12-14 mm open end wrench....1
  - 17-19 mm open end wrench....1
  - 3 mm Allen key....1
  - 4 mm Allen key....1
  - 5 mm Allen key....1
- **R***** - HELICAL CUTTER HEAD TOOLS/REPLACEMENT PARTS
  - Screw....10
  - Carbide insert....5
  - Star point screw driver....2

* The safety switch is not already installed on the base.
** Not included or required on "HC" model.
*** Included on "HC" model only.



PREPARATION AND PLACEMENT WITHIN THE SHOP

ADDITIONAL REQUIREMENTS FOR SET UP



- 3 Extra people to assist with lifting
- Straightedge
- 45° & 90° combination square
- Phillips Screwdriver
- Pliers or Vise-grips

CLEAN UP

The protective coating on the jointer tables prevents rust from forming during shipping and storage. Remove it by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations.)

A putty knife, held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing the saw's painted surfaces, as many solvent-based products will remove paint.

To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.

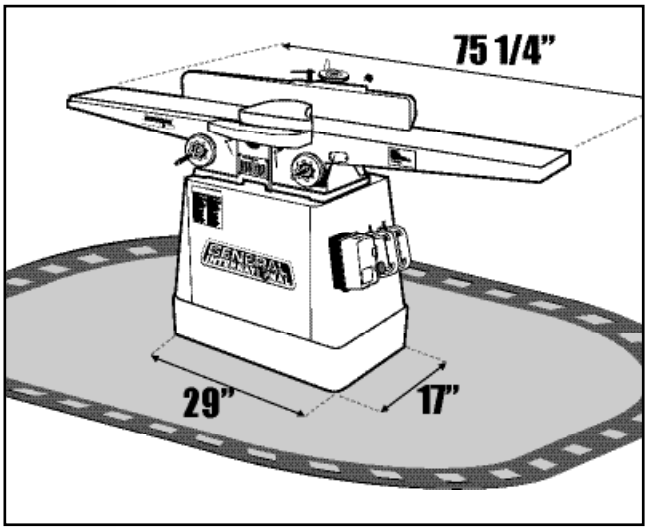
PLACEMENT WITHIN THE SHOP

THIS MODEL 80-200L/LHC JOINTER IS HEAVY – 572 LBS (260 KG). DO NOT OVER-EXERT. THE HELP OF OF AT LEAST THREE ASSISTANTS, A HOIST OR FORKLIFT WILL BE NEEDED FOR THE FOLLOWING STEP.

TO LIMIT THE RISK OF SERIOUS INJURY OR DAMAGE TO THE MACHINE, ANY EQUIPMENT USED TO LIFT THIS MACHINE (HOIST OR FORKLIFT) SHOULD HAVE A RATED CAPACITY IN EXCESS OF 572 LBS - 260 KG.

This machine should be installed and operated only on a solid, flat and stable floor that is able to support the weight of the jointer and the operator.

Using the dimensions shown as a guideline, plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic (either passing shop visitors or other shop workers) or other tools or machinery.



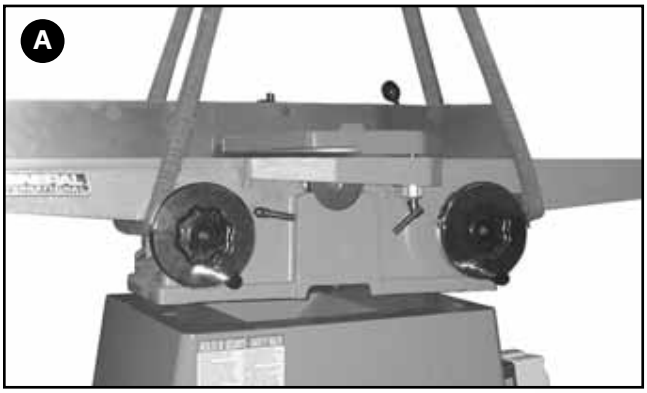
ESTABLISHING A SAFETY ZONE

For shops with frequent visitors or multiple operators, it is advisable to establish a safety zone around shop machinery. A clearly defined "no-go" zone on the floor around each machine can help avoid accidents that could cause injury to either the operator or the shop visitor. It is advisable to take a few moments to either paint (using non-slip paint) or using tape, define on the floor the limits or perimeter of each machines safety zone. Take steps to ensure that all operators and shop visitors are aware that these areas are off limits whenever a machine is running for everyone but the individual operating the unit.

ASSEMBLY INSTRUCTIONS

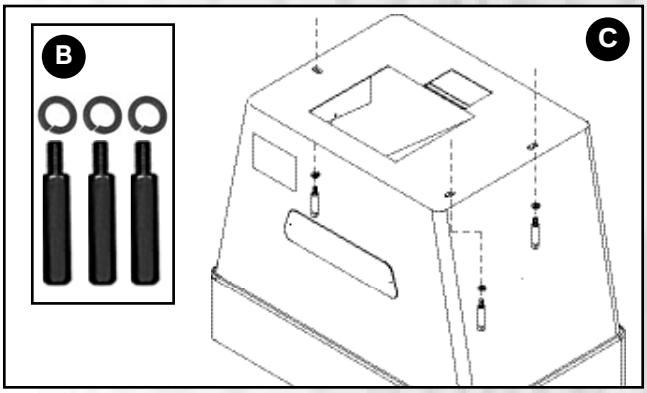
SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

ATTACH THE JOINTER BED TO THE BASE



THE JOINTER BED IS VERY HEAVY. DO NOT OVER-EXERT. THE HELP OF AT LEAST THREE ASSISTANTS WILL BE NEEDED FOR THE FOLLOWING STEP.

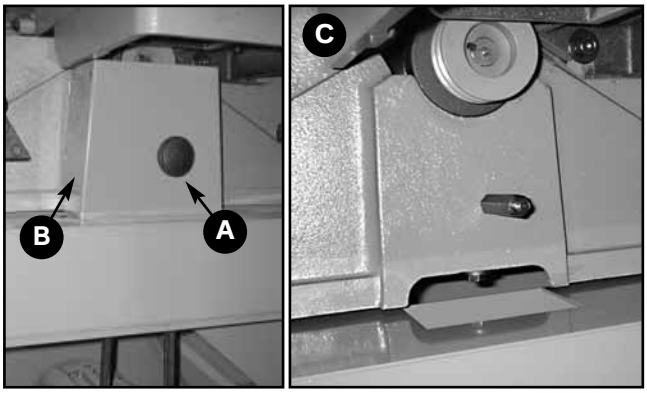
1. Using a hoist or with the help of three assistants, carefully lift the jointer bed onto the base **A**.



2. Align the 3 bolt holes on the jointer bed with the 3 holes on the base.
3. Use the supplied mounting bolts with lock washers **B** to bolt the jointer to the base through the 3 mounting holes from inside the cabinet and up into the bottom of the jointer bed **C**.

Note: Only hand-tighten the bolts for now. Final tightening will be done after pulley alignment.

INSTALL THE V-BELTS

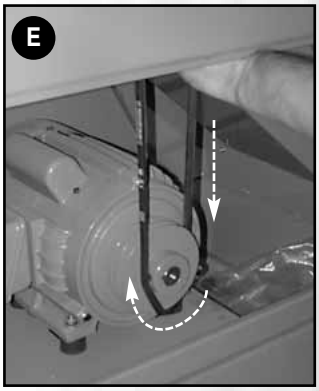


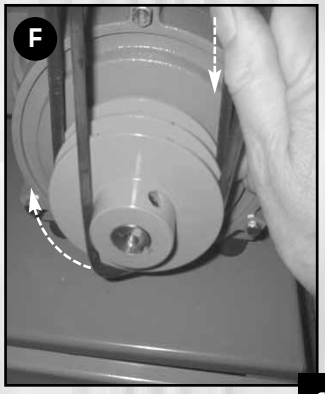
1. Loosen and remove knob **A**, then remove the upper pulley guard **B** to give yourself unimpeded access to the upper pulley **C**.

PULL SLOWLY - DO NOT USE SHARP TUGS! KEEP YOUR LOWER HAND FAR ENOUGH ABOVE THE MOTOR PULLEY TO AVOID PINCHING HAND BETWEEN THE BELT AND THE PULLEY.

3. Using both hands, carefully pull down on the belt to rotate the pulleys and allow the belt to seat itself in the groove, as shown in **E**.
4. Repeat step 3 to install the second belt **F**.

2. Place a V-belt on the inner groove on the upper pulley **D**, then fit and hold a portion of the opposite end of the belt into the corresponding groove on the motor pulley.

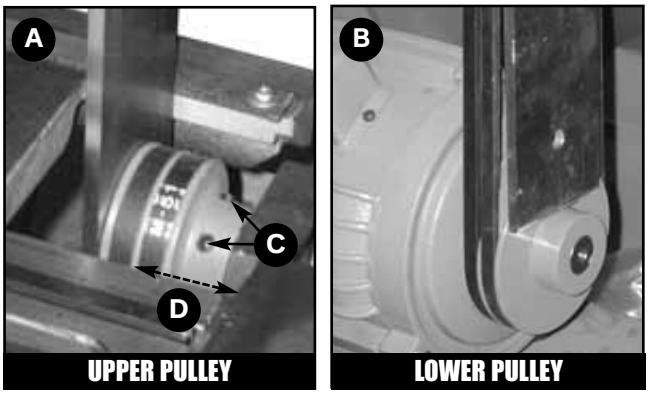




PULLEY PARALLEL ALIGNMENT

1. Hold a straight edge flush to the face of the upper pulley **A** to check alignment with the lower pulley, **B**.

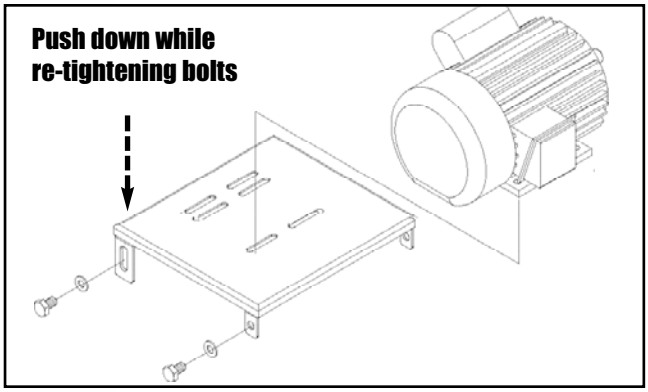
- If the pulleys are aligned: Fully tighten the bolts that secure the jointer bed to the stand.
- If the pulleys are not aligned: Adust the position of the jointer bed on the base to obtain pulley alignment then fully tighten the bolts that secure the jointer bed to the stand.



Note: If pulley alignment cannot be obtained, loosen both set screws C located on the upper pulley and slide the pulley on its shaft D to obtain parallel alignment then re-tighten the set screws.

VERIFY BELT TENSION

1. Push on the belts with your finger. The belts should not move more than 1/2".
2. If needed, tighten the belts by loosening the 4 motor bracket mounting bolts and lowering the bracket along the slotted holes, then re-tightening the bolts.



INSTALL THE CUTTER HEAD GUARD

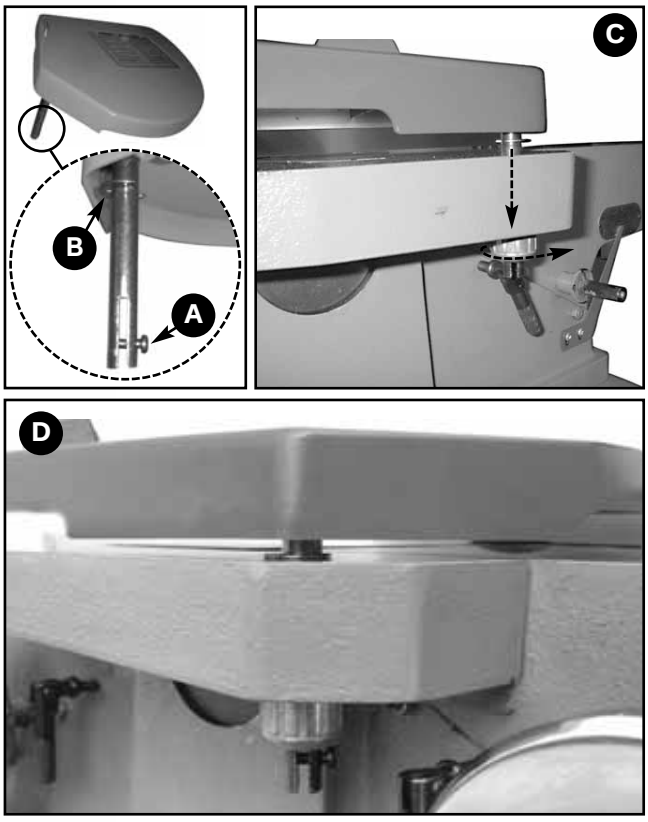
Tension is maintained on the cutter head guard using a spring loaded knob on the underside of the rabbetting arm. The tension causes the guard to automatically snap back against the fence and cover the knives once the workpiece has cleared the guard.

To install the guard:

1. Remove the set screw **A** on the guard shaft.
2. Turn and hold the tension adjustment knob and fit the shaft as far as it will go down into the mounting hole on the rabbeting arm at the front of the jointer **C**.

Note: The c-clip B on the shaft will keep the guard at the correct height above the tables.

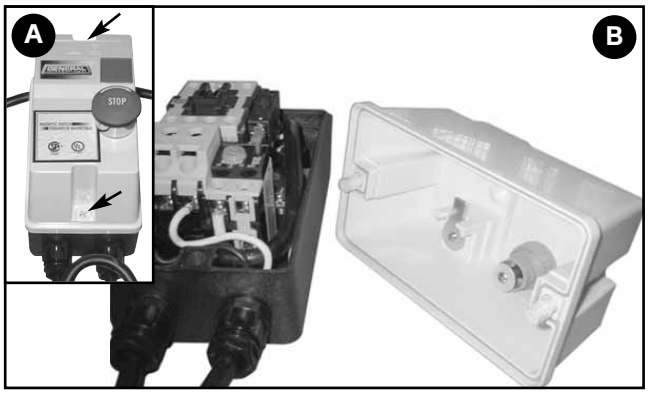
3. To test the tension, pull back on the guard bringing it away from the table and release.
4. If you find the tension on the guard does not snap the guard back firmly enough, hold the tension adjustment knob and remove the guard.
5. Turn the tension adjustment knob another 1/2 turn and re-install the guard.
6. Test the tension again and repeat steps 4 and 5 until adequate tension if achieved.



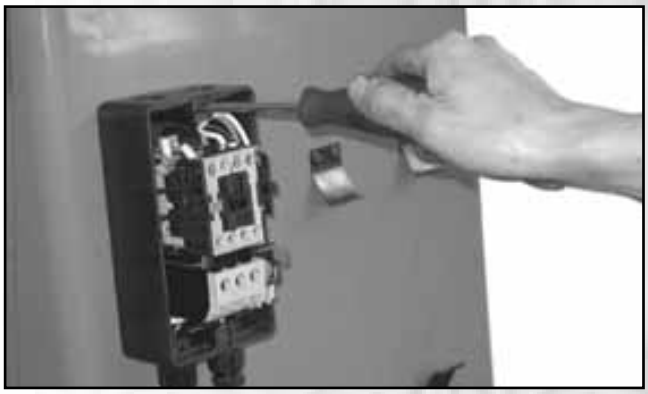
7. Tighten the stop screw on the bottom of the shaft **D** to secure the guard in place.

ATTACH THE SWITCH BOX / CONNECT TO THE MOTOR

MAKE SURE THAT THE JOINER IS NOT CONNECTED TO A POWER SOURCE.

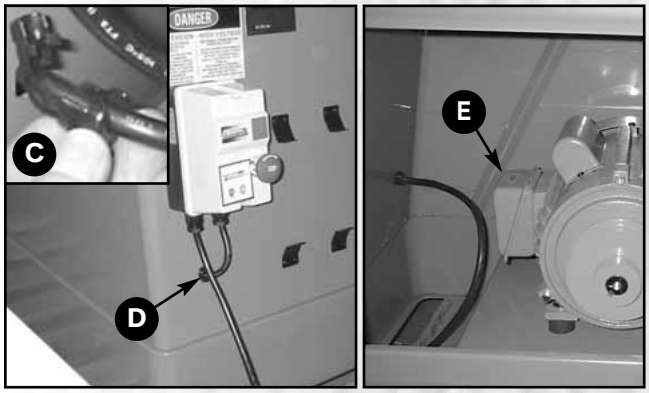


1. Loosen the two plastic screws **A** on the front of the switch box then remove the white cover **B**.

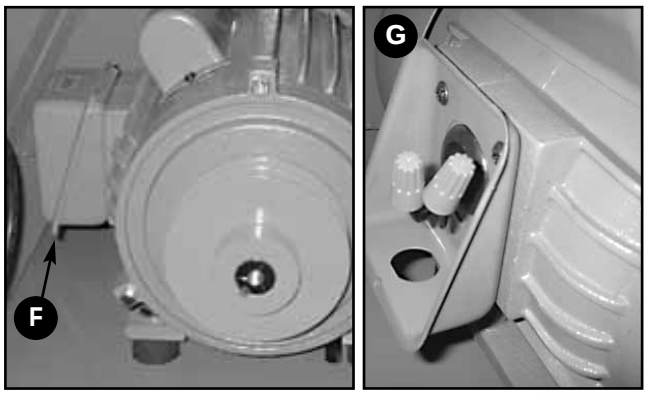


2. Attach the switch box to the right side of the base cabinet using the screws already mounted on the base.

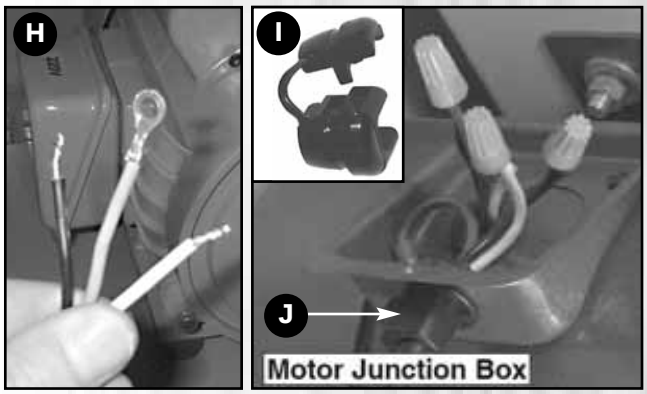
3. Re-install the switch box cover.



3. Run the power cord (with the strain relief attached **C**) from the bottom of the switch box into the opening in the base cabinet **D** making sure the cord reaches the connection box **E** on the motor.

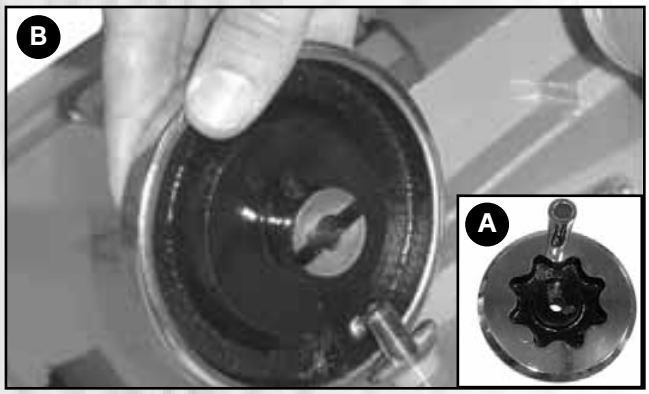


4. Loosen and remove the screw at the bottom of the motor connection box **F** and remove the cover **G**.

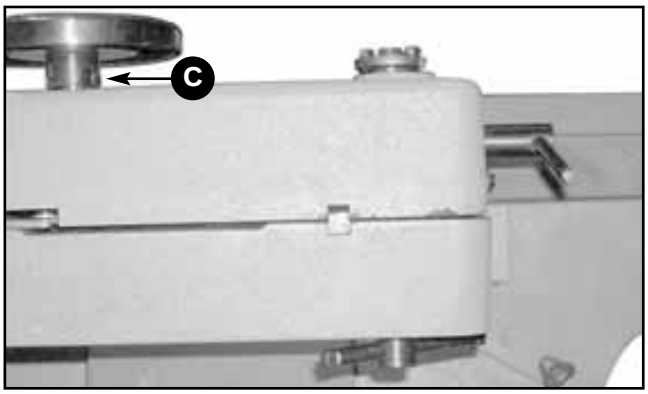


5. Attach the wires **H** and replace the cover using the supplied strain relief **I** to secure the cord in the opening at the bottom of the connection box **J**.

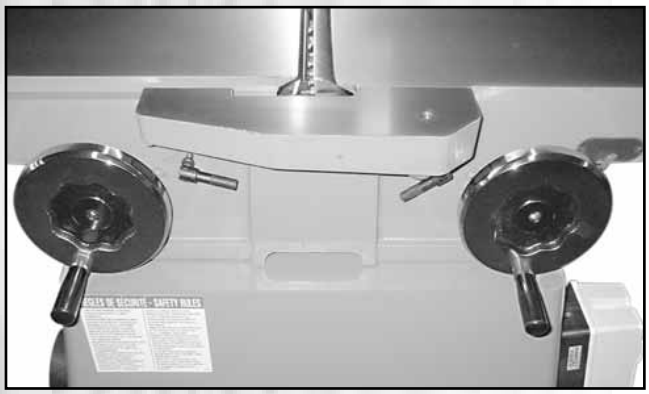
INSTALL THE FENCE AND TABLE HEIGHT ADJUSTMENT HANDWHEELS



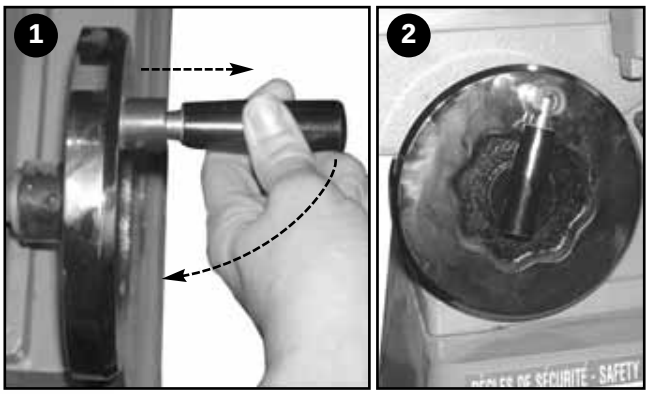
1. Fit the fence adjustment handwheel (the smallest one) **A** on the shaft on the rear fence bracket. The slots in the handwheel must be aligned with the spring pin on the shaft, **B**.



2. Using the supplied 3 mm Allen key, tighten the set screw on the shaft (under the wheel) to secure the handwheel to the shaft.

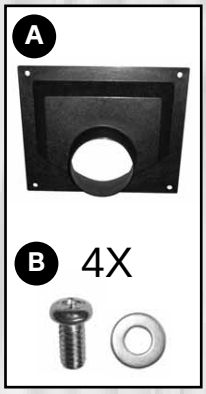


3. Repeat steps 1 and 2 with the two big handwheels on the shafts at the front of the machine



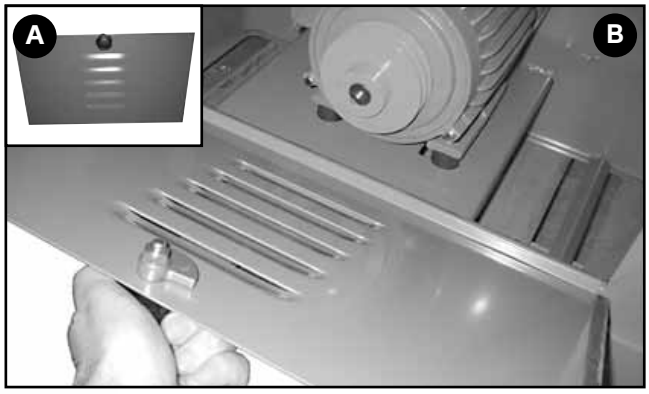
Note: The table height adjustment handwheels are equipped with spring loaded flip up handles to allow you to minimize the obstruction the handwheels may cause during jointing operations.

INSTALL THE DUST PORT



Attach the dust port **A** to the left side of the base using the supplied screws and flat washers **B**.

INSTALL THE BASE DOOR

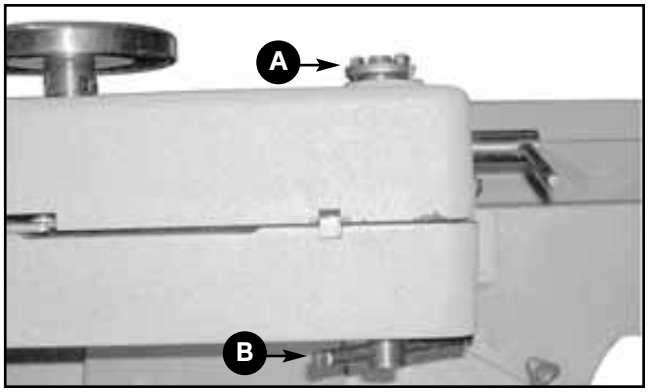


Install the base door **A** on the base as shown in **B**.

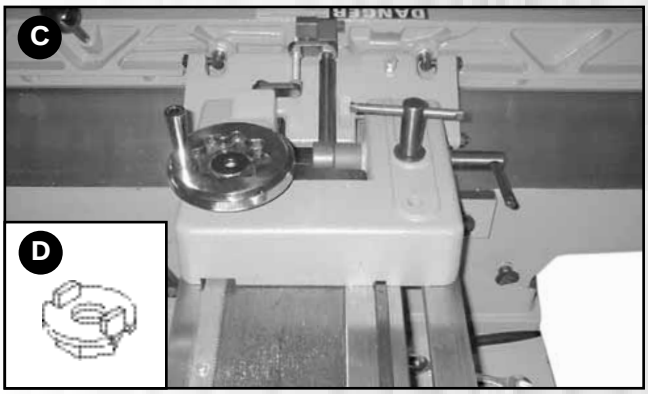
Note:

Four brackets are already installed on the right side of the base for convenient onboard storage of the 2 hand-paddle style push blocks supplied.

RE-POSITION THE FENCE LOCKING LEVER



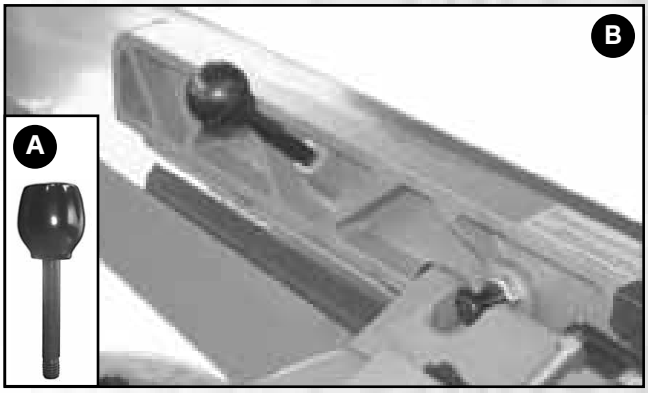
For shipping purposes the fence locking lever is installed upside down. Loosen and remove the lock nut **A** and remove the fence locking lever **B** and flat washer.



Re-install the locking lever with flat washer as shown in **C** and tighten with the lock nut, the lock nut oriented as shown in **D**.

INSTALL THE FENCE TILT LEVER

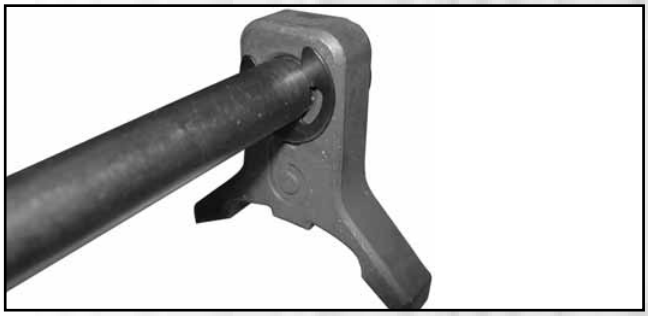
1. Thread the knob on the fence tilt lever **A**.
2. Screw the fence tilt lever into the threaded hole in the fence **B**.



ASSEMBLE THE KNIFE SETTING GAUGE

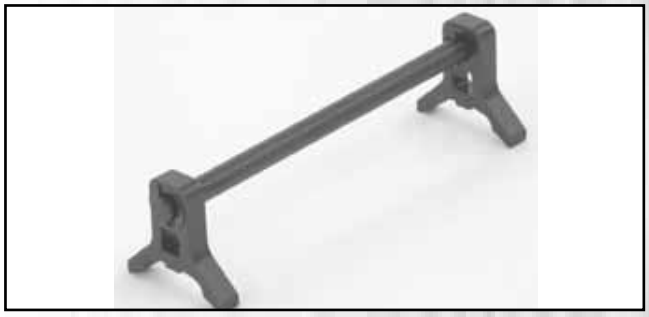
Note: Model 80-200L only. This gauge is not required on model 80-200LHC due to the helical cutter head design.

1. Using a pair of pliers, push a c-clip into the inner grooves on each end of the knife setting gauge rod.



2. Slide one foot onto one end of the rod.

3. Secure the foot on the rod by pushing a c-clip into the exposed groove in the rod.



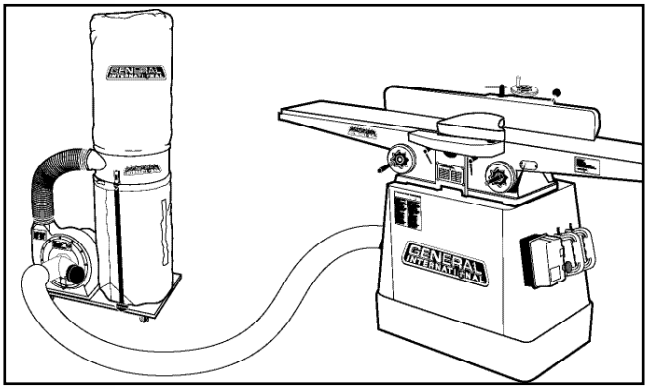
4. Repeat step 2 and 3 to install the other foot.
5. Set the gauge aside for use whenever knife settings need to be verified or adjusted.

CONNECTING TO A DUST COLLECTOR

A dust port with a 4" opening is provided to accommodate connection to a dust collector (not included).

Once the dust port has been installed, be sure to use appropriate sized hose and fittings (not included) and check that all connections are sealed tightly to help minimize airborne dust.

If you do not already own a dust collection system consider contacting your General® International distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at www.general.ca.

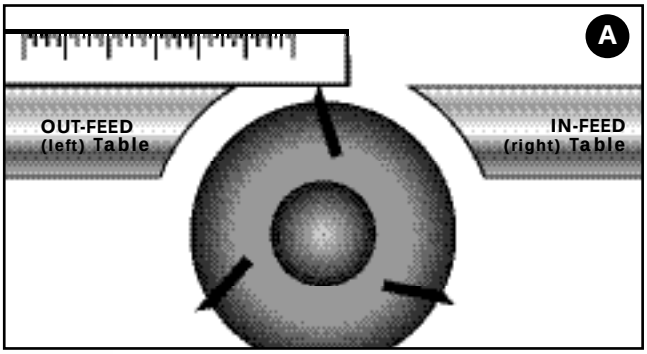


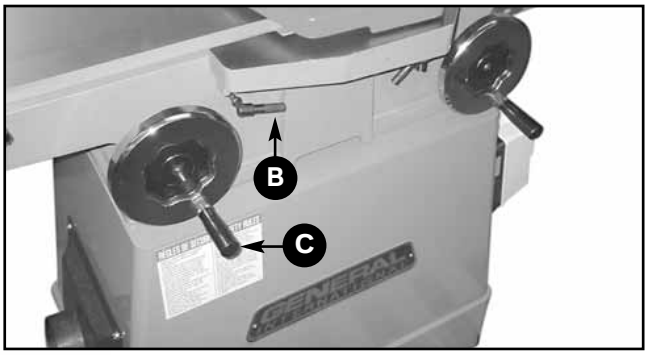
ADJUSTING AND SETTING THE OUT-FEED TABLE HEIGHT

The out-feed table should be set level with the highest point of the knives **A**. The height of the out-feed table should be verified and ajusted prior to first use. It should also be verified and re-adjusted periodically to compensate for knife wear and also upon knife replacement.

ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

1. Make sure that the the machine is disconnected from the power source.
2. To give yourself unimpeded access to the cutter head and upper pulley, remove the cutter head guard and fence.
3. Set a straightedge onto the out-feed table so that it sits over the cutter head but does not completely cross the gap between the tables and touch the in-feed table **A**.
4. Turn the upper pulley by hand, until any one of the knives is at it's highest point.
5. Loosen table locking lever **B** .
6. Use hand wheel **C** to adjust the out-feed table height so that the knife **barely touches** the straightedge.
7. Re-tighten locking lever **B** to secure the out-feed table in position.





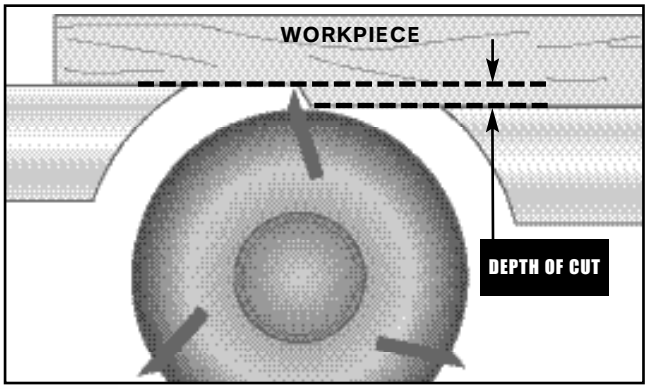
ADJUSTING AND SETTING THE IN-FEED TABLE HEIGHT / DEPTH OF CUT

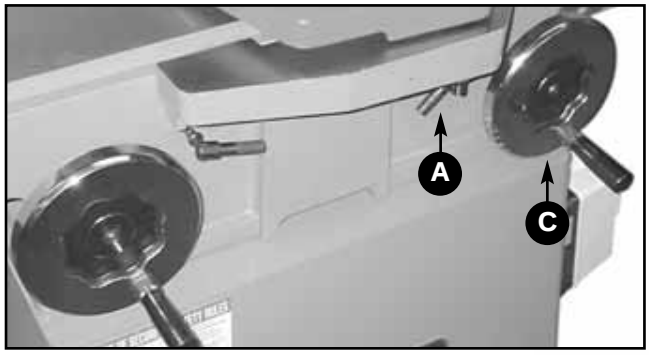
The depth of cut is set by raising or lowering the in-feed table.

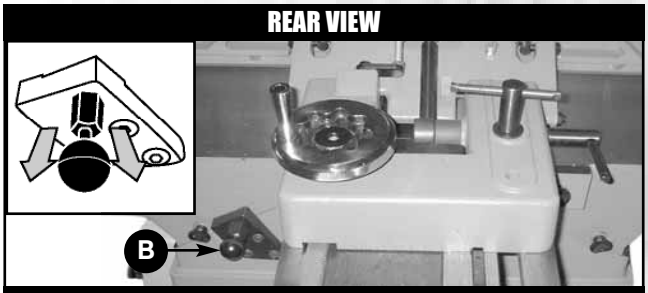
Refer to the recommended depth of cut settings in section "Basic Jointing Operations Instructions", on page 22.

THE MAXIMUM DEPTH OF CUT FOR ONE PASS IS 1/8". NEVER ATTEMPT TO REMOVE MORE MATERIAL THAN 1/8" IN ANY SINGLE PASS.

ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.





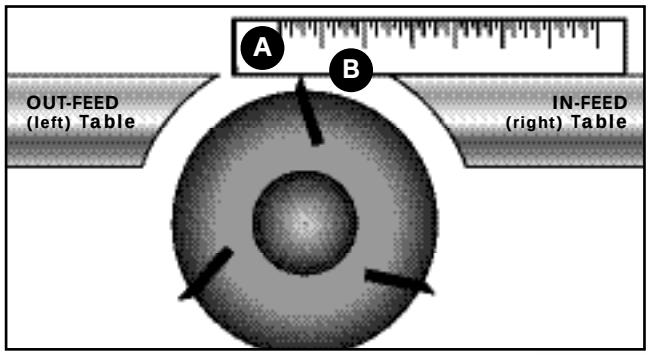


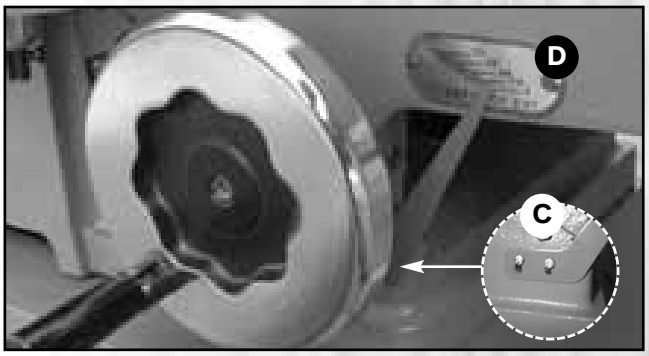
Important! Never adjust the table height with the lock-pin engaged as this will break the pin.

1. Loosen the in-feed table height locking lever **A**.
2. Pull & hold back the1/8" depth stop lock-pin **B.**
3. Use hand wheel **C** to adjust in-feed table height to the desired depth of cut and then release the 1/8" depth stop lock-pin and re-tighten locking lever **A** to secure the in-feed table in position.

CHECKING / ADJUSTING THE DEPTH OF CUT INDICATOR

The depth of cut indicator has been factory set to read "0" when the in-feed table is at the exact same height as the highest point of the cutterhead. However we recommend that you verify that the depth of cut indicator is properly set prior to first use. Also, with use and vibration over time, it may eventually become necessary to re-adjust the depth of cut indicator as follows:



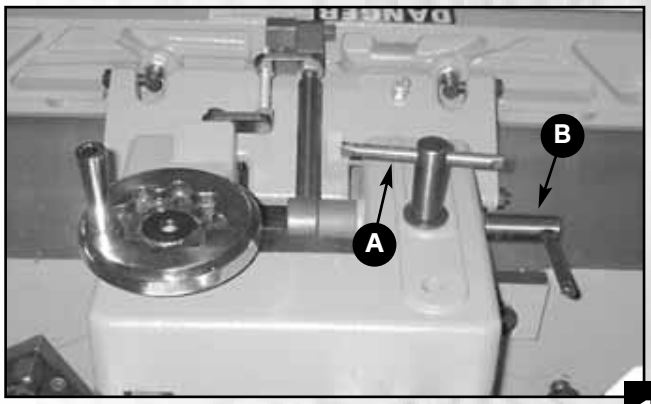


1. Set a straightedge onto the in-feed table so that it sits over the cutter head without completely crossing the gap between the tables to touch or sit above the out-feed table **A**.
2. Raise or lower the in-feed table until it is level highest point of the cutterhead **B**.
3. If needed, loosen the 2 screws **C** and adjust the pointer left or right until the pointer is set to the zero point on the scale **D**, then retighten the screws.

ADJUSTING THE FENCE & CHECKING / SETTING THE FENCE STOPS

The fence stops allow you to position the fence at specific pre-set angles in relation to the tables without having to measure each time you return to that angle.

Due to wear and vibration, fence stops can over time become misaligned and should be checked periodically and re-set if necessary.



<u>To move the fence front to back:</u>

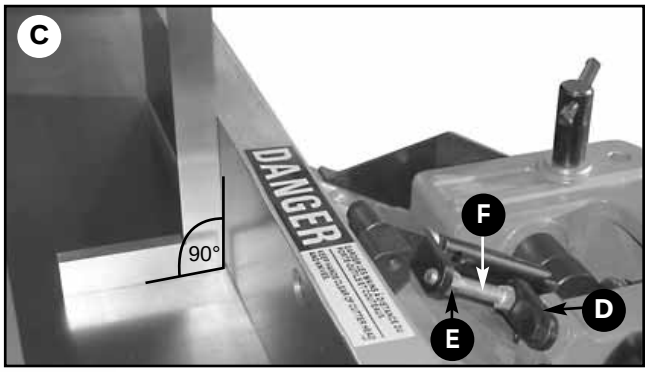
1. Loosen locking lever **A**.
2. Position the fence over the cutter head as needed.
3. Re-tighten locking lever **A**.

<u>To tilt the fence:</u>

1. Loosen locking lever **B**.
2. Set the fence 45° inward or 45° inward
3. Re-tighten locking lever **B**.

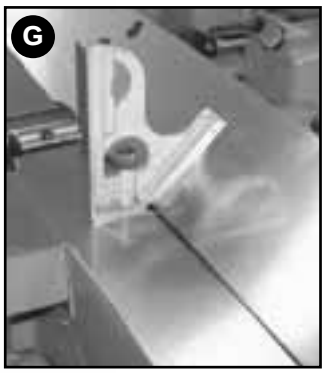
To set the **90°** fence stop:

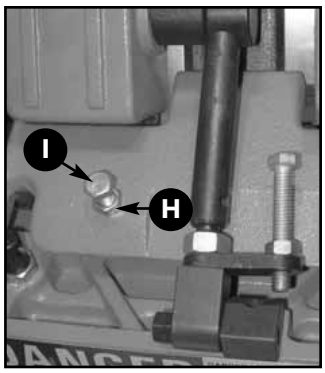
1. Using a 90° combination or machinists square, set the fence to 90° **C**.
2. Flip the 90° stop into position **D**.
3. Loosen the jam nut **E** on the 90° fence stop bolt.
4. Adjust the 90° fence stop bolt **F** until it makes contact with the 90° stop.
5. Retighten the jam nut.



To set the **45° outward** fence stop:

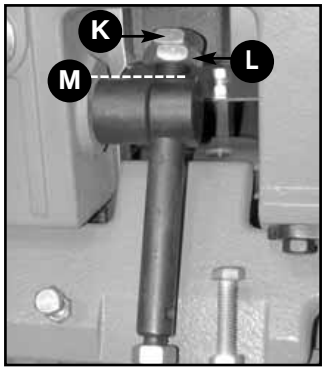
1. Using a combination or machinists square, set the fence to 45° outward **G**.
2. Loosen the jam nut **H** on the 45° outward fence stop bolt.
3. Adjust the 45° outward fence stop bolt **I** until it makes contact with the back of the fence.
4. Retighten the jam nut.





To set the **45° inward** fence stop:

1. Using a 45° combination or machinists square, set the fence to 45° inward **J**.
2. Loosen the jam nut **K**.
3. Adjust the 45° inward fence stop nut **L** until it makes contact with the 45° inward stop **M**.
4. Retighten the jam nut.



CHECKING KNIVES *(80-200L ONLY)*

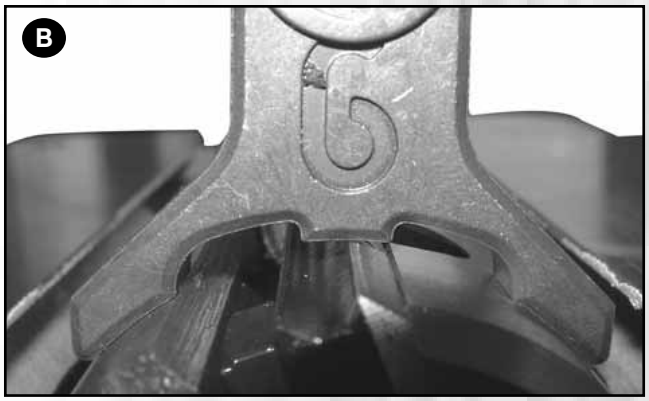
The knives have been factory set to the exact same height in the cutter head. However we suggest that you verify that the knives are properly set prior to first use.

Accurate work results can only be achieved when all three knives are properly installed and set to the exact same height in the cutter head. To verify if the knives are set properly, use the supplied knife setting gauge **A** following the steps below for each of the three knives:

ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

1. Make sure that the the machine is disconnected from the power source.
2. To give yourself unimpeded access to the cutter head and knives, remove the blade guard.
3. Using the table height adjustment hand wheels, lower the tables enough to allow the knife setting gauge to fit fully on the cutter head.
4. Remove the fence to have access to the upper pulley and turn it by hand to rotate the cutter head.

5. Set the gauge onto the cutter head with the center reference pads of the gauge sitting directly above a knife.
6. Observe how the gauge sits on the cutter head and how/if the knife touches the center reference pads. The ideal position has both sets of feet of the gauge sitting flush on the cutter head and the knife barely touching the center reference pads on the gauge **B**.
7. Should any (or all) of the knives not be set properly, follow the instructions in section "Knife Setting or Replacement", on page 24.



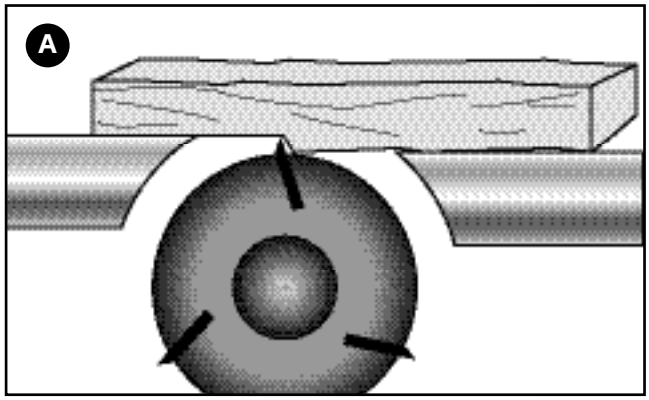
OPERATING INSTRUCTIONS

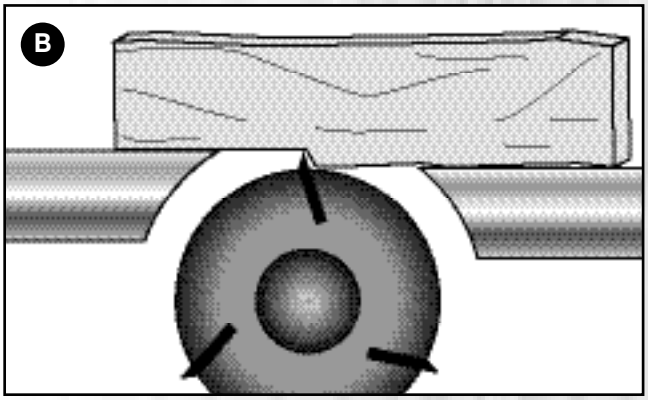
BASIC PRINCIPLES OF JOINTING

This jointer is designed to remove material from the bottom face of a board in order to bring one face of the board (or a series of boards) perfectly flat **A**.

This perfectly flat face is then placed against the fence, set at 90° to the tables, to obtain a perfectly perpendicular 90° flat edge **B**.

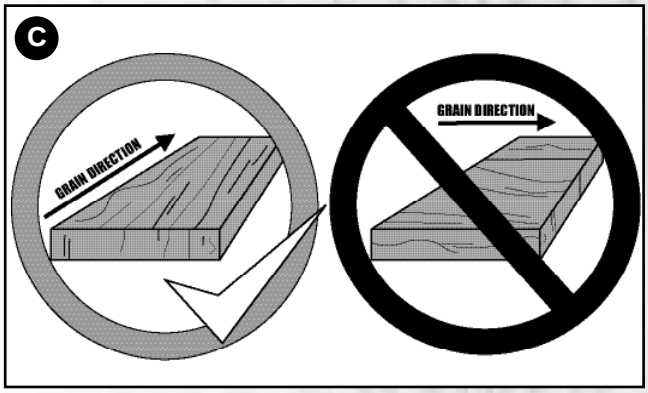
This jointer is not intended (and should not be used) to joint any material other than solid wood.





SELECTING BOARDS SUITABLE FOR JOINTING

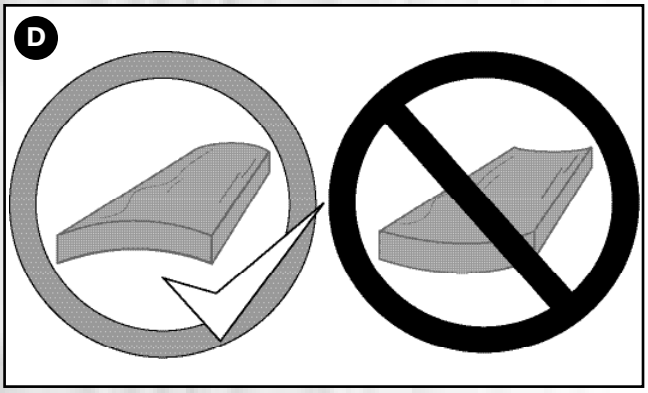
1. Jointing safety begins with the stock used with the machine. Inspect the work piece carefully before jointing it. Never joint a board that has loose knots, staples, nails or other embedded foreign objects. If you have the slightest doubt about the structural integrity or stability of a board: **Do Not Joint It.**
2. Only boards with the grain running more or less lengthwise are suitable for jointing **C**.

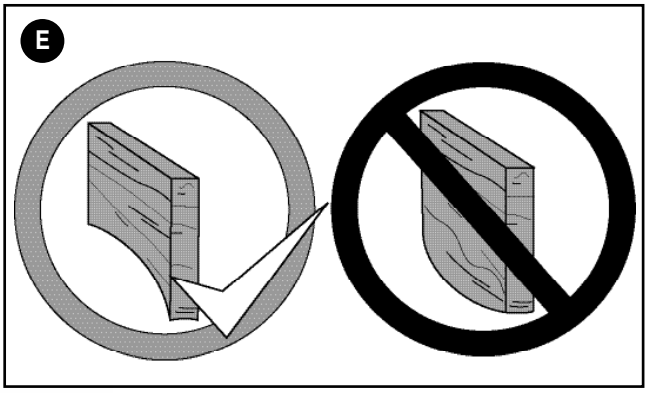


ALWAYS JOINT IN THE GENERAL DIRECTION OF THE GRAIN. JOINTING AGAINST THE GRAIN OR JOINTING END GRAIN IS DANGEROUS AND MAY CAUSE THE WORKPIECE TO SHATTER.

DETERMINE THE CONCAVE FACE AND EDGE OF YOUR BOARD

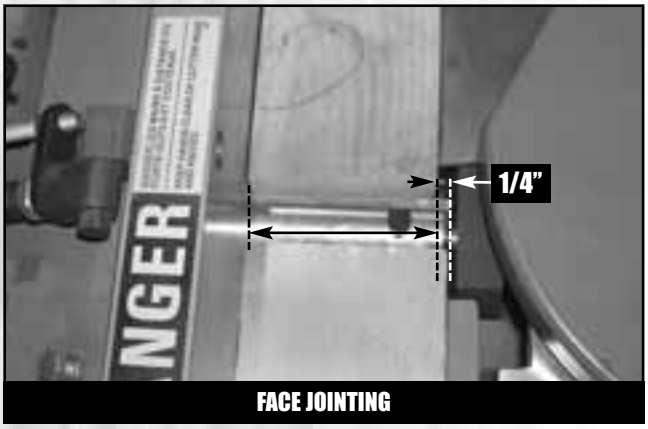
Place your board on a flat surface to identify its concave face **D** and edge **E.** The boards must be jointed with its concave face and edge against the jointer table.



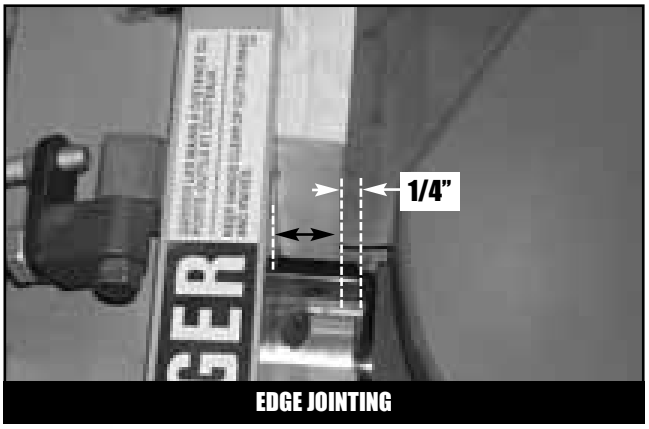


ADJUST FENCE FRONT TO BACK POSITION

To limit your exposure to the knives in the cutter head, never take more knife length than is required to complete the cut. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.



FACE JOINTING



EDGE JOINTING

CHECKLIST BEFORE STARTING

VERIFY ALL CHECK POINTS BEFORE STARTING. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES.

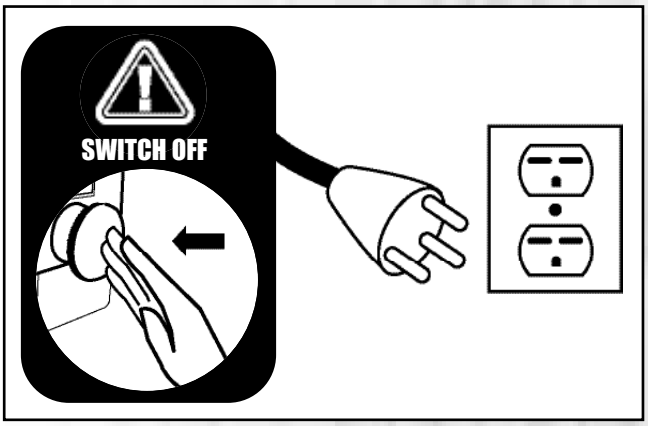
- Make sure you and any assistants are wearing safe appropriate workshop attire. Roll up long sleeves, secure long hair and remove any jewelry: watches, rings, bracelets or anything that could become caught in the moving parts, potentially causing serious injury.
- Make sure the board has been inspected and is suitable for jointing as explained in the previous section "Selecting boards suitable for jointing".
- Verify that the cutter head guard is functioning properly (snaps back against the fence and covers the knives).
- Make sure that the fence is properly set and locked in place.
- Make sure to have on safety glasses as well as hearing and respiratory protection at all times when using the jointer.

CONNECTING TO A POWER SOURCE

TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY.

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

Once the assembly and adjustment steps have been completed, uncoil the power cord and plug it into an appropriate outlet. Refer back to the section entitled "ELECTRICAL REQUIREMENTS" and make sure all requirements and grounding instructions are followed. When jointing operations have been completed unplug the jointer from the power source.

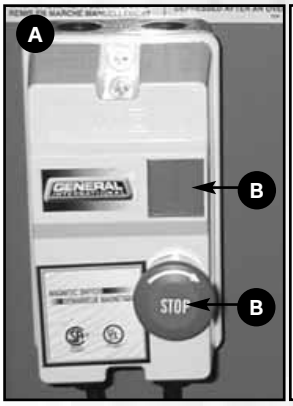


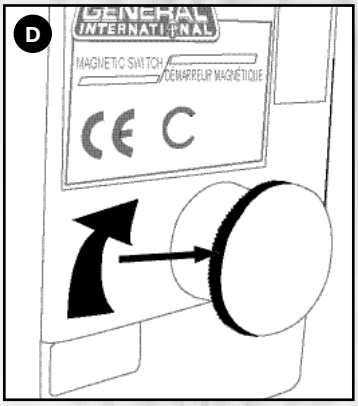
MAGNETIC SAFETY SWITCH

This model 80-200L/LHC jointer is equiped with a MAGNETIC SAFETY SWITCH **A** designed to protect the unit and the user from power surges, power outages and unwanted or unintentional start-up.

The switch assembly is equipped with a GREEN "START" button **B** and a RED spring loaded "STOP" button **C**.

Once the RED "STOP" button has been pressed, the machine can only be started by turning the BLACK inner part of the button to the right to release the stop button, **D**.





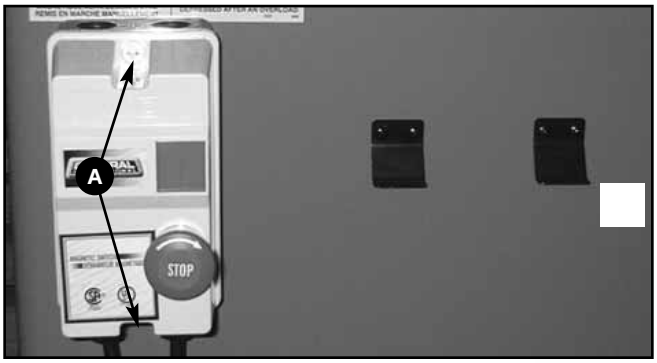
OVERLOAD PROTECTION

The magnetic safety switch on this jointer is equipped with an overload protection feature. To prevent an electrical overload from damaging the motor, in the event of a spike in line voltage or amperage draw, the internal overload protector will automatically be tripped, thereby cutting off power to the motor. To reset the overload protection switch after it has been tripped proceed as follows:

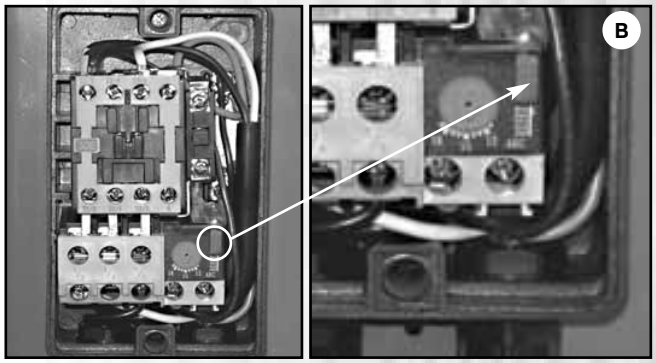
Note: The most common causes of such overloads are:

1. ***Overworking the motor by attempting to remove too much material in one single pass or by feeding the workpiece too quickly, thereby causing an increase in power consumption and a spike in amperage draw.***
2. ***An electrical extension cord that is too long or not the correct gauge of wire, which can also cause an increase in amperage draw. If an electric extension cord must be used, follow the instructions and refer to the chart in the electrical requirements section at the beginning of this manual.***
3. ***Overworked circuit caused by operating on a circuit that is close to its amperage draw capacity. Make sure the circuit being used is capable of handling the amperage draw from this machine as well as any other electrical devices operating on the same circuit. If you are unsure, consult a qualified electrician.***

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH ON THE SAW IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE. .



1. Unscrew the 2 screws **A** and remove the control box front cover.



2. Press the red reset button **B**.

3. Reinstall the control box cover.

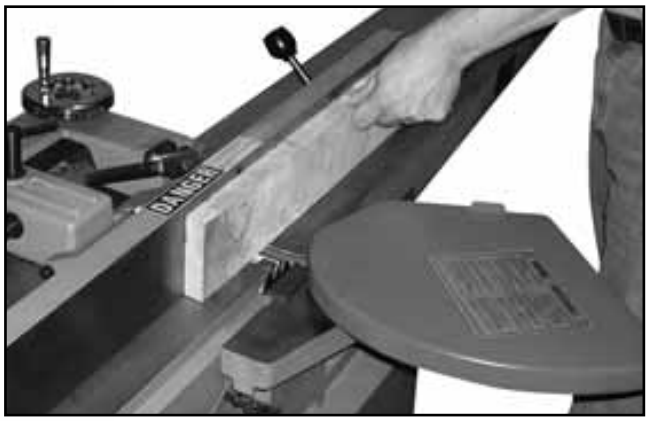
BASIC JOINTING OPERATIONS

SURFACE PLANING

1. Inspect the stock before starting & remove any foreign objects or debris.
2. Set the depth of cut as required (1/32" is recommended for face planing - Less for hard wood or wider stock.)
3. Set & lock the fence at 90°.
4. If your workpiece is cupped, place the cupped side face down on the infeed (right) table.
5. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.
6. Turn on the machine & using push blocks press the stock against the table and tight to the fence, feeding the stock over the cutter head.
7. Inspect the board & repeat the steps if needed until the surface is flat.

FAILURE TO USE PUSH BLOCKS WHEN SURFACE PLANING MAY RESULT IN SERIOUS PERSONAL INJURY. ALWAYS USE PUSH BLOCKS TO HELP KEEP YOUR HANDS AT A SAFE DISTANCE FROM THE KNIVES WHEN SURFACE PLANING.

EDGE JOINTING



1. Inspect the stock before starting & remove any foreign objects or debris.
2. Set the depth of cut as required (1/16" - 1/8" is recommended for edge jointing - Less for hard wood or wider stock.)
3. Set & lock the fence at 90°
4. If your workpiece is cupped, place the cupped side face down on the infeed (right) table.
5. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.
6. Turn on the machine, press the stock against the table and tight to the fence, feeding the stock over the cutter head.
7. Inspect the board & repeat the steps if needed until the surface is flat.

RABBETING

1. Remove the blade guard & move the fence forward leaving only the width of the desired rabbet on the tables uncovered by the fence & lock the fence in position.

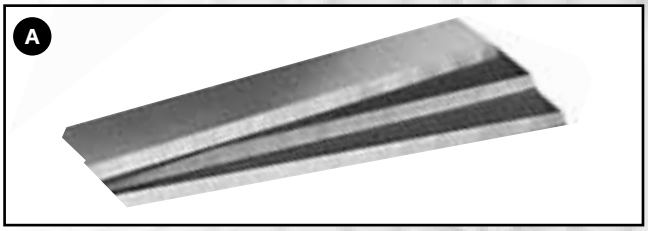
REMOVE THE BLADE GUARD FOR RABBETING ONLY. IMMEDIATELY REPLACE THE BLADE GUARD WHEN FINISHED. DO NOT PERFORM ANY OTHER JOINTING OPERATION WITH THE BLADE GUARD REMOVED. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

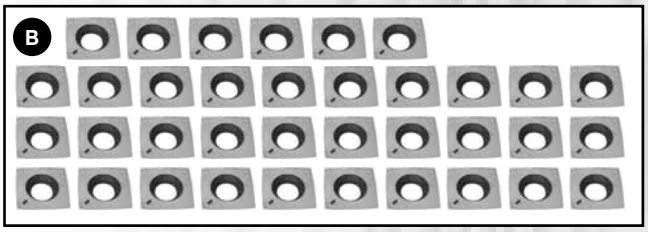
2. Inspect the stock before starting & remove any foreign objects or debris.
3. Set the depth of cut as required (1/16" - 1/8" is recommended for rabbeting - Less for hard wood or wider stock.)
4. Turn on the machine & using push blocks press the stock against the tables rabbeting arm and tight to the fence, feeding the stock over the cutter head.
5. Repeat the steps until the rabbet is cut to desired depth.

MAINTENANCE

MAKE SURE THE JOINTER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

INSPECTING/REPLACING CUTTER HEAD KNIVES





Model 80-200L only:

There are 3 knives installed in the cutter head at the factory. With usage and normal wear over time, it will eventually become necessary to replace the knives. To maintain even knife wear always replace all 3 knives at the same time.

When needed, replacement knives (sold in sets of 3) **A** can be ordered through your local General International distributor under part #80-205 (High Speed Steel) or #80-210 (Carbide).

Model 80-200LHC only:

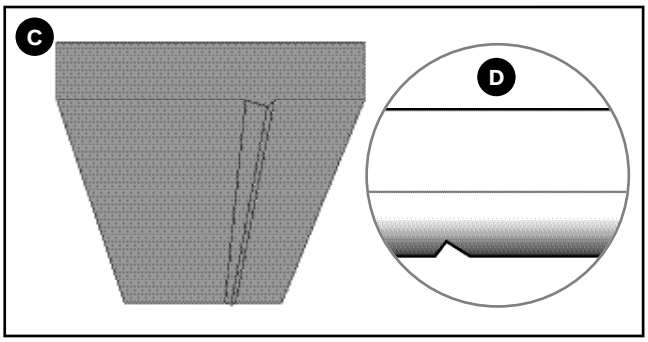
There are 36 four-sided carbide inserts (knives) installed in the helical cutter head at the factory. With usage and normal wear over time, it will eventually become necessary to reverse and/or replace the inserts. To maintain even insert wear always reverse all 36 inserts each time knife replacement is required. If one of the inserts has been nicked or damaged on one of it's edges, it can be simply reversed instead of replaced.

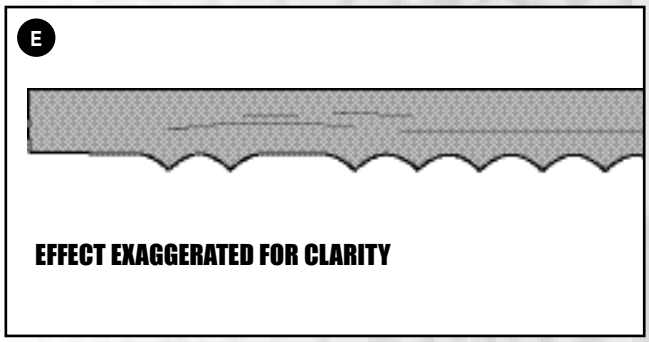
When needed, replacement inserts **B** can be ordered through your local General International distributor under item #30-447.

ALL Models:

Observing jointed workpieces as they come off of the machine and looking for signs of knife damage or wear is the best method to help you to determine when knives are due to be changed.

Signs to look for include:





1. A raised ridgeline in the workpiece that runs a straight line from beginning to end of the board **C**. This is generally an indication that one or more knives has been nicked or damaged **D** by a foreign object such as a nail, staple or other hard object hidden or embedded in the workpiece.
2. A slight washboard or chatter effect **E** which can be an indication of uneven knife wear causing one knife to cut slightly deeper than the others.
3. Rough, irregular, torn or fuzzy grain on a freshly jointed surface may be a sign of worn or dull blades causing the wood to tear out. Sharp blades cut crisply and leave a relatively smooth finish.

Note: Fuzzy grain can also be a sign of high moisture content in the workpiece. If knives have recently been changed or if you suspect that moisture content and not dull knives is the cause, set the workpiece aside and test by jointing other boards with known or acceptable moisture content. If the jointed results using a different workpiece are smooth, then moisture content in your wood is the problem - no adjustments can be made to the machine for this. Set the "wet" stock aside and simply work with drier wood.

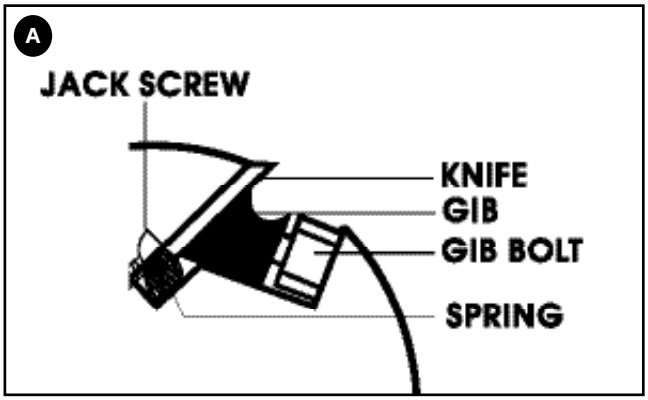
KNIFE SETTING OR REPLACEMENT - *MODEL 80-200L ONLY*

Properly setting all three knives is essential to achieving accurate work results. Properly set knives will last longer and also keep their edge (sharpness) longer by equally sharing the cutting workload. You may use the supplied knife setting gauge to help you set the knives to the correct height whenever re-setting or changing knives.

Note: If you prefer you may also find other "aftermarket" gauges, jigs or knife setting tools that are to your liking – ask your local tool distributor for information on any such tools that may be available in your market.

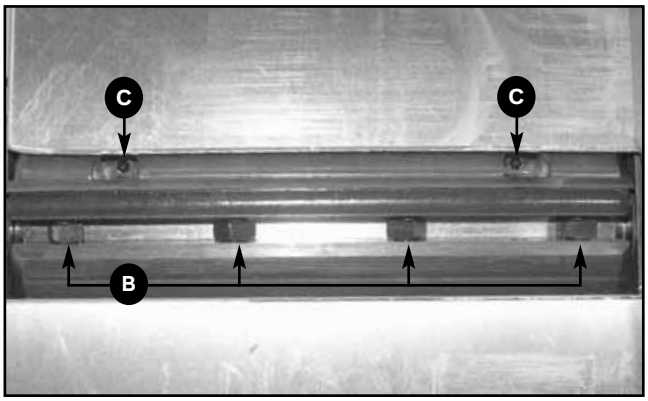
The cutter head on this unit is supplied with both adjustment springs and jack screws **A** providing you with two options for setting the knives. We suggest you try each method at least once or twice and decide for yourself which method works best and fastest for you.

KNIVES ARE VERY SHARP. USE CARE WHEN HANDLING KNIVES.



1. Turn off and disconnect the machine from the power source.

2. To give yourself unimpeded access to the cutter head and knives, remove the blade guard and lower the tables as far as they go.

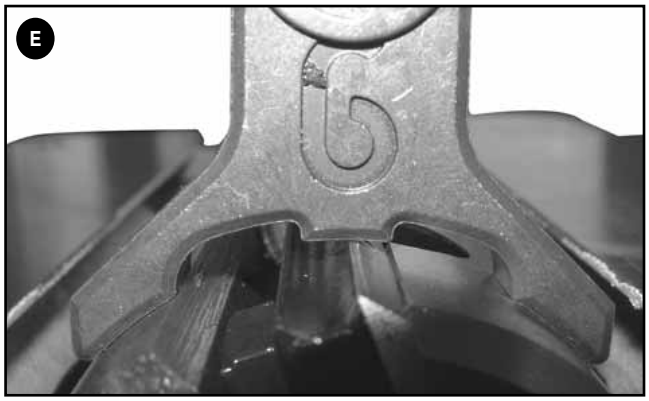


3. Remove the fence to have access to the upper pulley and turn it by hand to rotate the cutter head to access one of the knives.

4. Loosen (but don't remove) all the gib bolts **B** – start in the center and alternate sides (If replacing an old or damaged knife, loosen the bolts until the knife can be removed and install a new sharpened knife). Then position the gauge over the selected knife **D**.

5. **a)** <u>To use the adjustment springs to set the knife height</u>: Push the knife down with the gauge so that the edge of the knife is touching the center reference pads on the gauge **E**. Hold the gauge down and tighten the bolts **B** to secure the knife in place. Repeat for the 2 other knives.

   b) <u>To use the Jack Screws to set the knife height</u>: Use an Allen wrench to turn the screws **C** to raise or lower the knife as needed until the ideal position - both sets of feet of the gauge sitting flush on the cutter head and the knife barely touching the center reference pads on the gauge **E** – has been achieved. Repeat for the 2 other knives.



6. Re-check the height setting on all the knives and re-set if necessary.

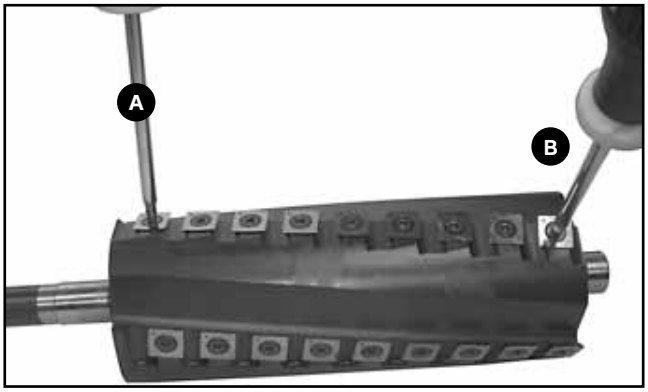
7. Reset the tables and replace the fence and blade guard.

IMPORTANT! After changing or resetting the knives, the out-feed (left) table height must be re-adjusted to match the new height of the knives. Follow the instructions in section "Adjusting and Setting the Out-Feed Table Height" on page 16.

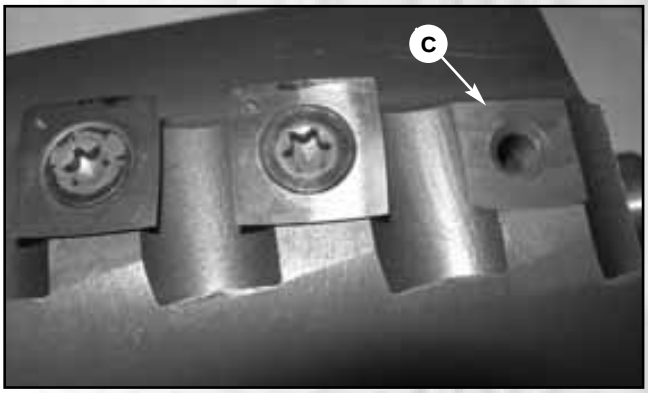
HELICAL CUTTER HEAD INSERT REVERSAL / REPLACEMENT - *MODEL 80-200LHC ONLY*

INSERT EDGES ARE VERY SHARP. USE CARE WHEN HANDLING INSERTS.

MAKE SURE ALL INSERTS ARE FIRMLY SECURED IN THE CUTTER HEAD. LOOSE INSERTS COULD BE EJECTED FROM THE CUTTER HEAD AT HIGH SPEED AND LEAD TO SERIOUS INJURIES.

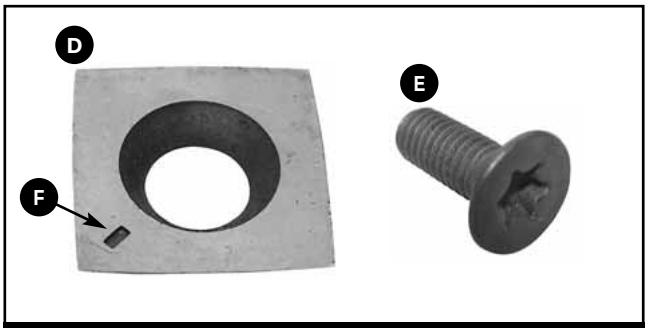


1. Insert one of the two supplied star-point screwdrivers into the head of one screw **A** to prevent the cutter head from rotating while loosening another screw **B**.



2. Remove the screw and insert.

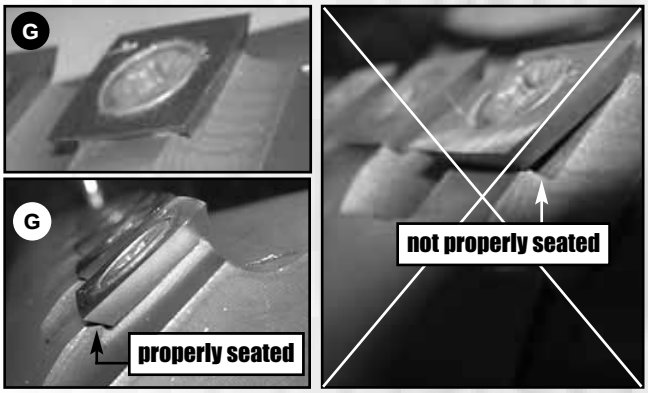
3. Thoroughly clean the housing and cavity **C** before reversing/replacing an insert.



Important! To prevent knife height discrepencies, the inserts and screws must be clean and free of debris.

4. Thoroughly clean the inserts **D** and screws **E** using a lacquer thinner and small brush then apply a light coating of machine oil on the screws, taking care to remove any excess.

Tip: When reversing the inserts in the cutter head, refer to the etched mark* F *on the inserts to keep track of the rotations.



5. Place the insert on the housing so it sits flush against the supporting edge as shown in **G** and firmly secure it in place with a screw.

Note: To avoid stripped screws and cracked inserts, do not overtighten the screws

Note: If a torque tool (not included) is used to tighten the screws, a pressure of 60kg-cm is recommended.

Note: When tightening the screws, make sure the head of the screw is aligned with the hole of the insert as shown in H.

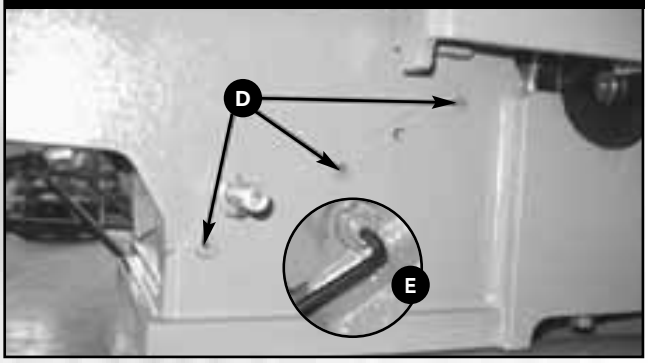
IMPORTANT! After reversing or changing the knives, the out-feed (left) table height must be re-adjusted to match the new height of the knives. Follow the instructions in section "Adjusting and Setting the Out-Feed Table Height" on page 16.

ADJUSTING THE GIBS

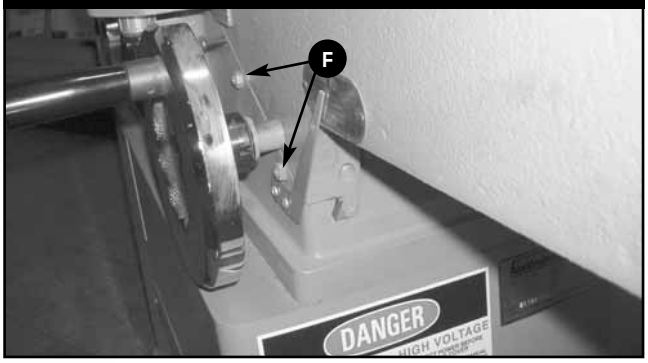
The table gibs allow you to eliminate excessive play when raising/lowering the tables and, when properly adjusted, will allow for a smoother and easier table height adjustment.

1. Loosen the three gib nuts at the front of the out-feed table **D**.
2. Using the supplied Allen key, tighten all three gib set screws **E** an equal amount then test raising/lowering the table. Continue to adjust the set screws as needed until you find the right balance between easy movement and minimal play.
3. Repeat these steps for the in-feed table gib nuts **F**, then verify and adjust (if necessary) the out-feed table height following the instructions in section "Adjusting and Setting the Out-Feed Table Height" on page 16.

OUT-FEED TABLE



IN-FEED TABLE



PERIODIC MAINTENANCE

To prolong the service life of your jointer and to maintain optimum performance the following basic maintenance procedures should be practiced and become part of your shop routine.

- Inspect/test the ON/OFF switch before each use. Do not operate the jointer with a damaged switch; replace a damaged switch immediately.
- Keep the machine as well as the in-feed out-feed tables clean and free of saw dust, woodchips, pitch or glue. Vacuum or brush off any loose debris and wipe down the machine and the tables occasionally with a damp rag.
- An occasional light coating of paste wax can help protect the tables' surface and reduce workpiece friction. Ask your local distributor for suggestions on aftermarket surface cleaners, protectant and dry lubricants based on what is readily available in your area.
- Avoid using silicon based products that may affect or react with wood finishing products such as oil, solvent or water-based stains, varnishes and lacquers.
- Periodically inspect the power cord and plug for damage. To minimize the risk of electric shock or fire, never operate the planer with a damaged power cord or plug. Replace a damaged power cord or plug at the first visible signs of damage.
- All bearings are sealed and permanently lubricated and no further lubrication is required. The fence assembly and table ways also should not be lubricated. If you should encounter a "sticking" problem, simply disassemble and clear away any obstructions from the ways.
- Regularly inspect jointed workpieces for signs of knife damage or wear and replace damaged or worn knives immediately.
- Inspect the belts regularly – To avoid potentially costly downtime, consider keeping spare replacement belts on hand for use if needed. Belts that show visible signs of wear such as cracks or fraying at the edges should be replaced immediately.

RECOMMENDED OPTIONAL ACCESSORIES

We offer a large variety of products to help you increase convenience, productivity, accuracy and safety when using your jointer Here's a small sampling of optional accessories available from your local General International dealer. For more information about our products, please visit our website at www.general.ca

DUST COLLECTORS

Dust collectors contribute to a cleaner more healthful workshop environment.

We offer a wide selection of top quality dust collectors to suit all your shop needs.

Electronic Earmuffs # 99-200

Highly efficient noise reduction to help protect your hearing when operating power tools.

Magnetic micro-adjustable planer and jointer knife alignment gauge - # 30-025

Keeps knives in perfect alignment, accurate to +/- 0.001". Suitable for all planer and jointer knives from 6" – 26" in length. The easiest way to set planer and jointer knives.

Dial-gauge micrometer for knife alignment - # 30-050

Precision built, easy to adjust, mounted on enamel finished alloy steel. Designed to rest squarely on the cutter head for fast accurate knife alignment. Dial is easy to read and adjust.

Jointer knife alignment Jig - # 30-075

8 7/8" Alloy steel bars with 3 magnetic points for precise alignment of jointer knives. Assures perfect finished cuts to an accuracy of ± 0.001" (±0.025 mm). Can be used on most jointer models.

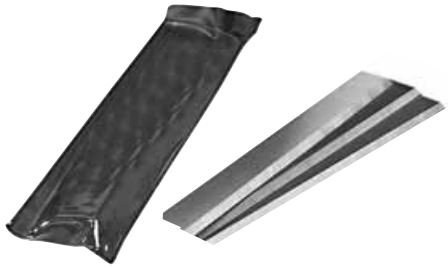
"BYRD" Style Helical cutter head - # 200HB

4 rows, total: 36 inserts

Replacement inserts - # 30-447

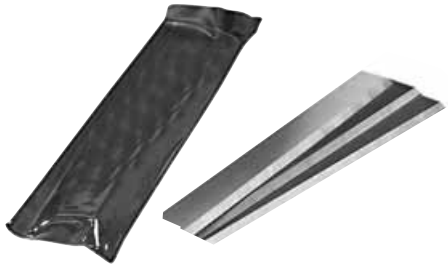
Replacement Jointer Knives - # 80-205

Set of three 8" High Speed Steel jointer knives.

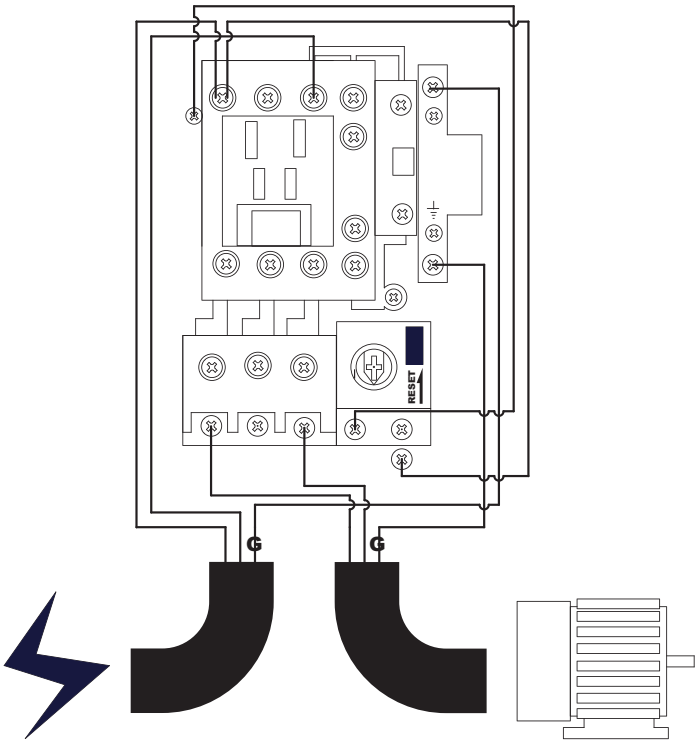


Replacement Jointer Knives - # 80-210

Set of three 8" Carbide jointer knives.



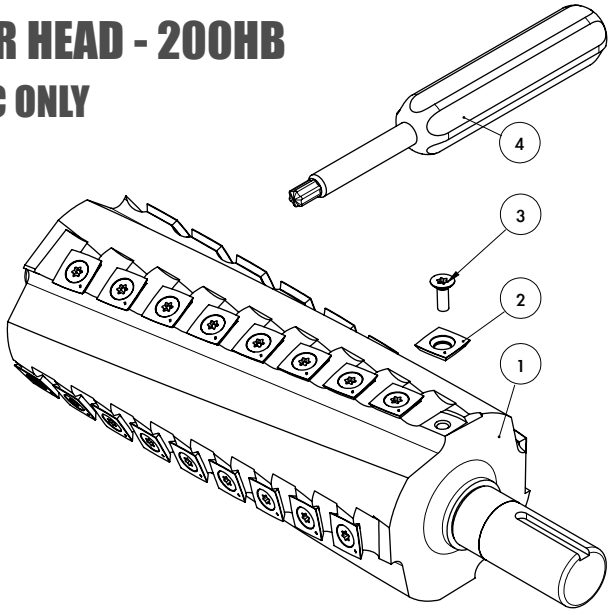
WIRING DIAGRAM



PARTS LIST & DIAGRAMS

HELICAL CUTTER HEAD - 200HB

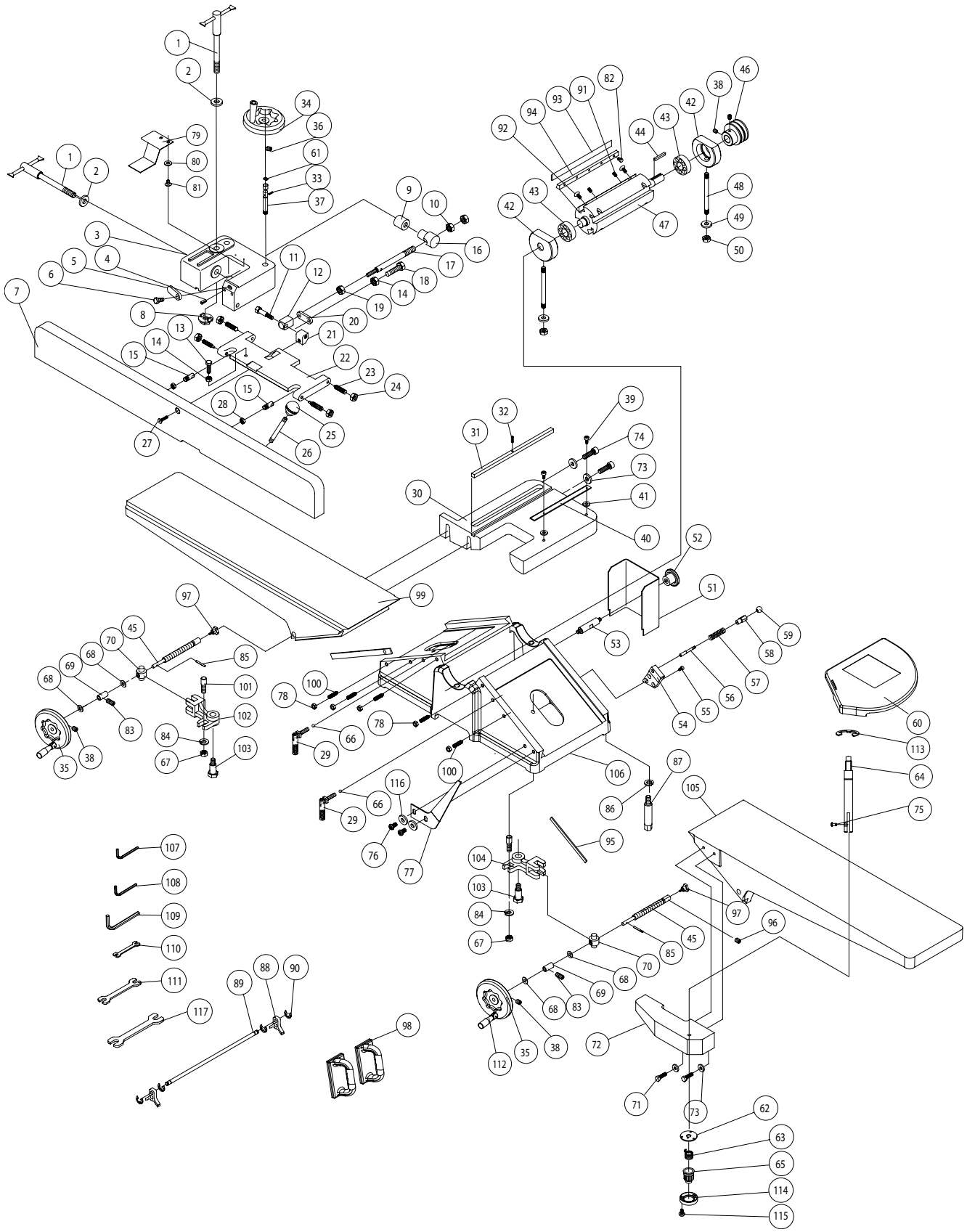
MODEL 80-200LHC ONLY



PARTS LIST 80-200LHC

REF N0.	PART N0.	DESCRIPTION	SPECIFICATION	QTY
1	200HB-01	CUTTER HEAD		1
2	30-447	CARBIDE INSERT	15 X 15 X 2.5 MM	36
3	200HB-03	SCREW	#10-32UNC	36
4	200HB-04	SCREW DRIVER	T-25	2

HEAD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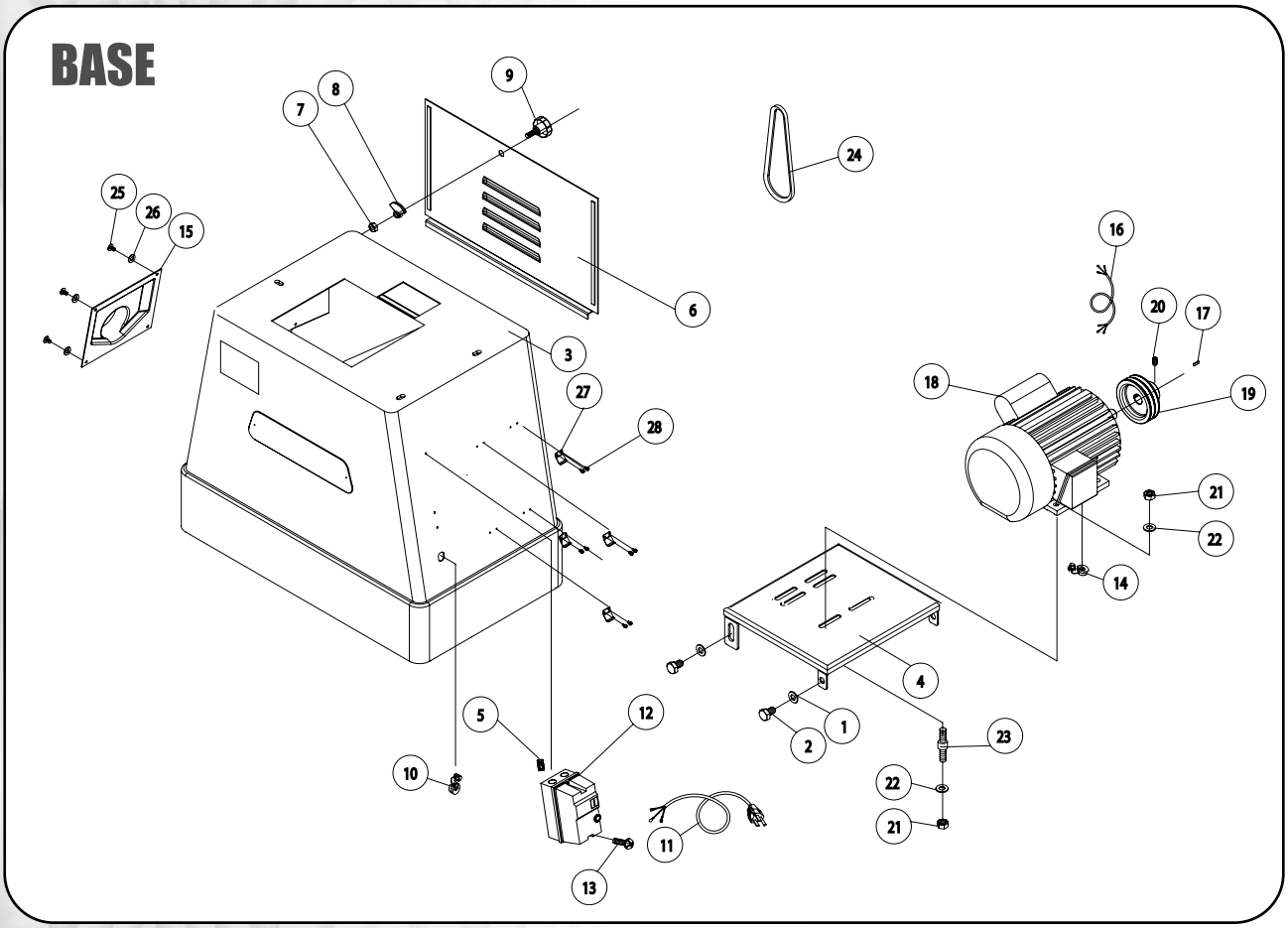
PARTS LIST - 80-200L - HEAD

PART N0.	REF. N0.	DESCRIPTION	SPECIFICATION	QTY
80200L-1	JE030001	LOCKING BOLT		2
80200L-2	HE019600	WASHER	13X28X3T	2
80200L-3	JG200005	FENCE BRACKET		1
80200L-4	HG010906	SPRING PIN	4X12	2
80200L-5	JE030005	STOPING BLOCK		1
80200L-6	JE030004	HEX HEAD BOLT		1
80200L-7	JG090001	FENCE BODY		1
80200L-8	JE260017	NUT		1
80200L-9	JE030016	SPACER		1
80200L-10	HX012400	HEX. NUT	5/8"-18NF	2
80200L-11	JE030010	HEX. HD. SCREW		1
80200L-12	JE030011	JOINT BLOCK		1
80200L-13	HT010912	HEX. HD. SCREW	5/16"-18NCX1-1/4"	1
80200L-14	HX010700	HEX NUT	5/16"-18NC	5
80200L-15	JG130004	BOLT	1/2" - 20NC	2
80200L-16	JE030015	SWIVEL BLOCK		1
80200L-17	JG090003	LINKAGE		1
80200L-18	HT010916	HEX. SCREW	5/16"-18NCX1-3/4"	1
80200L-19	HX011200	HEX. NUT	7/16"-20NC	1
80200L-20	JE030013	STOP PLATE		1
80200L-21	JE030012	BLOCK		1
80200L-22	JG010002	FENCE LINK		1
80200L-23	JE030020	BOLT	3/8"-16NC	2
80200L-24	HD010900	HEX. NUT	3/8"-16NC	4
80200L-25	JE0R0101	KNOB		1
80200L-26	JE0R0102	HANDLE		1
80200L-27	HB080915	FLAT HD. BOLT	5/16"-18NCX1-5/8"	1
80200L-28	HX011400	NUT	1/2"-20NF	2
80200L-29	JG080001	UNIVERSAL HANDLE		2
80200L-30	JG200006	BRACKET		1
80200L-31	JG010020	KEY		1
80200L-32	HG010907	SPRING PIN	4X14	1
80200L-33	HG010914	SPRING PIN	4X25	2
80200L-34	JE0401	HANDWHEEL		1
80200L-35	JG2002	HANDWHEEL		2
80200L-36	HB030705	SET SCREW	1/4"-20NCX3/8"	6
80200L-37	JG200009	SHAFT		1
80200L-38	HB030805 S	SET SCREW	5/16"-18NCX3/8"	4
80200L-39	HA020308	CAP SCREW	M5X0.8PX16	2
80200L-40	JG180010	GEAR BAR		1
80200L-41	HE012500	WASHER	6.5X16X2.0	2
80200L-42	JG010012	BEARING HOUSING		2
80200L-43	HJ032200	BEARING	6204NSE	2
80200L-44	HH010412	KEY	5X5X22	1
80200L-45	JG200011	SHAFT		2
80200L-46	JG010014	UPPER PULLEY		1
80200L-47	JG0L0101	CUTTER HEAD		1
80200L-48	JG200014	BOLT		2
80200L-49	JG010011	WASHER		2
80200L-50	HX011000	HEX. NUT	3/8"-24UNF	2
80200L-51	JG100001	PULLEY GUARD		1
80200L-52	PJ030001	KNOB		1
80200L-53	PJ030003	BOLT		1
80200L-54	JG20007	FIXED PLATE		1
80200L-55	HB020908	CAP SCREW	5/16"-18NCX3/4"	3
80200L-56	JG040007	PIN		1
80200L-57	JG040008	SPRING		1
80200L-58	JG040005	SPRING SEAT		1
80200L-59	JE020007	KNOB		1

PARTS LIST - 80-200L - HEAD

PART N0.	REF. N0.	DESCRIPTION	SPECIFICATION	QTY
80200L-60	JG200021	CUTTER HEAD GUARD		1
80200L-61	HF010900	RETAINING RING	STW-11	1
80200L-62	JE010014	RETAINING WASHER		1
80200L-63	JE010015	SPRING		1
80200L-64	JG200024	SHAFT		1
80200L-65	JE010016	SPRING KNOB		1
80200L-66	HL011200	BALL	F6	2
80200L-67	HX011500	HEX. NUT	1/2"-12NC	2
80200L-68	JG200018	COPPER WASHER		4
80200L-69	JG200008	RING		2
80200L-70	JE010703	COPPER NUT		2
80200L-71	HB011110	CAP SCREW	3/8"-16NCX1"	2
80200L-72	JG200020	RABBETTING ARM		1
80200L-73	HE015600	WASHER	10.5X28X3	4
80200L-74	HB021012	CAP SCREW	3/8"-16NCX1-1/4"	2
80200L-75	JG0101	SCREW		1
80200L-76	HA040404	ROUND HEAD SCREW	M4X0.7PX10T	2
80200L-77	JG200016	INDICATOR		1
80200L-78	HX010500	HEX. NUT	1/4"-20NC	6
80200L-79	JG040002	SAFETY PLATE		1
80200L-80	HY011900	WASHER	6.6X13X1T	2
80200L-81	HB051006	FLAT HEAD SCREW	1/4-20NCX1/2"	2
80200L-82	JE010102	SCREW	1/4"-28NFX7MM	15
80200L-83	HB030808	SET SCREW	5/16-18NCX3/4"	2
80200L-84	HE021600	LOCK WASHER	13X22.7	2
80200L-85	HG010814	SPRING PIN	3X25	2
80200L-86	HE021300	LOCK WASHER	10.2X18.5	3
80200L-87	JE010029	LOCK BOLT		3
80200L-88	JG1P0101	KNIFE SETTING GAUGE		2
80200L-89	JG1P0102	ROD		1
80200L-90	HF031800	E-RING	ETW-9	4
80200L-91	PJ0L0103	SPRING		6
80200L-92	HA080305	FLAT HD. SCREW	M5X0.8PX12	6
80200L-93	JG0L0102	KNIFE		3
80200L-94	JG0L0104	KNIFE LOCKING BAR		3
80200L-95	JG010508	BAR		2
80200L-96	HB030805	SET SCREW	5/16"-18NCX3/8"	2
80200L-97	JE010003	KNOB	5/16"-18NC-3/5"	2
80200L-98	JE030021	PUSH BLOCK		2
80200L-99	JG200012	REAR TABLE		1
80200L-100	JE010706	SET SCREW		6
80200L-101	JG200013	PIN		2
80200L-102	JE010711	BALL CRANK		1
80200L-103	JG200010	SHAFT		2
80200L-104	JE010709	BALL CRANK		1
80200L-105	JG200003	FRONT TABLE		1
80200L-106	JG200004	BASE		1
80200L-107	HQ010400	ALLEN KEY	3MM	1
80200L-108	HQ010500	ALLEN KEY	4MM	1
80200L-109	HQ010600	ALLEN KEY	5MM	1
80200L-110	HQ020400	OPEN END WRENCH	8-10MM	1
80200L-111	HQ020900	OPEN END WRENCH	12-14MM	1
80200L-112		HANDLE		2
80200L-113	HF032000	RETAINING RING	ETW-12	1
80200L-114	JE010017	RETAINER		1
80200L-115	HA040604	ROUND HEAD SCREW	M5X0.8PX10	1
80200L-116	HY010600	WASHER	4.3X10X1T	2
80200L-117		OPEN END WRENCH	17-19MM	1

BASE

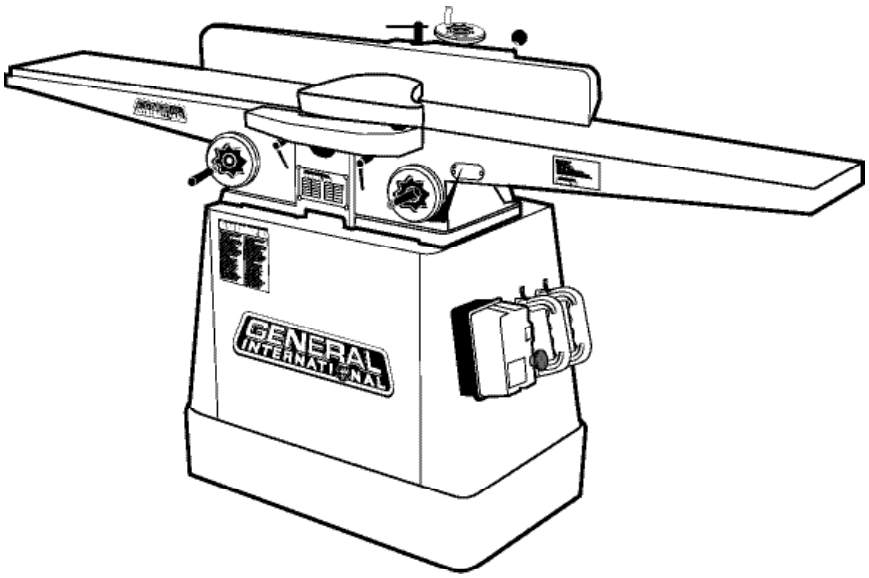


PARTS LIST 80-200L - BASE

PART N0.	REF. N0.	DESCRIPTION	SPECIFICATION	QTY
80200L-B01	HE019600	WASHER	13X28X3T	4
80200L-B02	HT011510	HEX HD. BOLT	1/2"-12NCX1"	4
80200L-B03	JG110101	STAND		1
80200L-B04	JG010302	MOTOR MOUNT		1
80200L-B05	HP170100	STRAIN RELIEF	1/2"	2
80200L-B06	JG010304	COVER		1
80200L-B07	HX010900	NUT	3/8"-16NC	1
80200L-B08	JE010031	KEY		1
80200L-B09	JE010030	SCREW		1
80200L-B10	HN031100	STRAIN RELIEF	SB8R-3	1
80200L-B11	PJOF0801	POWER CORD	14AWGX3CX2000MM	1
80200L-B12	821018-007	SWITCH		1
80200L-B13	HT040916	SCREW	3/16"-24NCX1-3/4"	2
80200L-B14		STRAIN RELIEF		1
80200L-B15		DUST CHUTE		1
80200L-B16	PJODOA01	MOTOR CORD	14AWGX3CX850MM	1
80200L-B17	HH030415	KEY	5X5X30	1
80200L-B18	PJOAOA01	MOTOR	2HPX230VX60HZX1PH	1
80200L-B19	JG010032	MOTOR PULLEY		1
80200L-B20	HB030905	SET SCREW	3/8"-16NCX3/8"	2
80200L-B21	HW010800	HEX NUT	M8X1.25	8
80200L-B22	HY019800	WASHER	8.4X15.5X1.6	8
80200L-B23	JG070002	VIBRO ELIMINATOR		4
80200L-B24	HK013800	V-BELT	M51	2
80200L-B25		SCREW		4
80200L-B26		WASHER		4
80200L-B27		SPRING PLATE		4
80200L-B28		SCREW		8

Notes

MODELS 80-200L & 80-200LHC



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IMPORTANT

When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.